

(19)



(11)

EP 3 667 041 B1

(12)

EUROPEAN PATENT SPECIFICATION

(45) Date of publication and mention
of the grant of the patent:

13.10.2021 Bulletin 2021/41

(51) Int Cl.:

F02B 19/16 ^(2006.01) **F02B 43/00** ^(2006.01)
F02B 19/10 ^(2006.01) **F02B 19/18** ^(2006.01)
F02B 19/12 ^(2006.01) **F02M 21/02** ^(2006.01)

(21) Application number: **18861842.5**

(86) International application number:

PCT/JP2018/031833

(22) Date of filing: **28.08.2018**

(87) International publication number:

WO 2019/065053 (04.04.2019 Gazette 2019/14)

(54) **AUXILIARY CHAMBER TYPE GAS ENGINE**

GASMOTOR MIT HILFSKAMMER

MOTEUR À GAZ DE TYPE À CHAMBRE AUXILIAIRE

(84) Designated Contracting States:

**AL AT BE BG CH CY CZ DE DK EE ES FI FR GB
GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO
PL PT RO RS SE SI SK SM TR**

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(43) Date of publication of application:
17.06.2020 Bulletin 2020/25

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Description

TECHNICAL FIELD

[0001] The present disclosure relates to a precombustion chamber gas engine for combusting an air-fuel mixture in a main combustion chamber by injecting a plurality of combustion flames generated in a precombustion chamber via a plurality of nozzle holes to the main combustion chamber.

BACKGROUND

[0002] Conventionally, a precombustion chamber gas engine including a main combustion chamber (main chamber) defined between a piston and a cylinder head and a precombustion chamber (auxiliary chamber) communicating with the main combustion chamber via a plurality of nozzle holes is known (for example, Patent Document 1). The precombustion chamber gas engine ignites an air-fuel mixture in the precombustion chamber by an ignition device such as an ignition plug, and jets combustion flames generated by the ignition via each of the nozzle holes disposed at the tip of the precombustion chamber, by which a lean premixed gas in the main combustion chamber is combusted.

[0003] Patent Document 1 discloses that the inner wall of the precombustion chamber expands with increasing (raising) temperature of the inner wall to about 1000°C, and the expanded inner wall contracts with decreasing temperature, and that the repeated expansion and contraction of the inner wall of the precombustion chamber causes heat fatigue, which may cause a crack in the inner wall. Further, JP5357926B discloses that the crack often occurs in the vicinity of the precombustion-chamber-side opening edge of the nozzle hole.

[0004] To solve the above problem, in JP5357926B, on the basis of findings that the crack in the vicinity of the precombustion-chamber-side opening edge is caused due to temperature of the precombustion-chamber-side opening edge significantly raised compared to the surrounding portion, the precombustion-chamber-side opening edge of the nozzle hole is formed with a curved surface having a certain curvature radius to reduce the temperature difference between the opening edge and the surrounding portion.

[0005] EP 1 777 385 A2, US 5,950,593, EP 2 700 796 A1 and WO 91/12418 A1 disclose precombustion chamber gas engines with the pre-characterizing features of claims 1 and 2.

SUMMARY

Problems to be Solved

[0006] Indeed, in JP5357926B, the occurrence of crack at the precombustion-chamber-side opening edge is suppressed compared to when the precombustion-

chamber-side opening edge is not formed with a curved surface, but the effect obtained by forming the curved surface is limited, and a further measure is necessary to further suppress the occurrence of crack.

[0007] In view of the above circumstances, an object of at least one embodiment of the present invention is to provide a precombustion chamber gas engine that can reduce thermal stress generated around nozzle holes and suppress the occurrence of crack around the nozzle holes.

Solution to the Problems

[0008] This object is solved by a precombustion chamber gas engine with the features of claim 1 or 2. Preferred embodiments follow from the other claims.

[0009] A precombustion chamber gas engine according to a first aspect of the present invention comprises: a main-chamber forming portion forming a main combustion chamber; and a precombustion-chamber forming portion forming a precombustion chamber communicating with the main combustion chamber via a plurality of nozzle holes. The precombustion-chamber forming portion includes a cylindrical portion extending along an extension direction of a precombustion chamber central axis of the precombustion-chamber forming portion, and a tip portion closing a main-combustion-chamber-side end of the cylindrical portion and having the nozzle holes. The tip portion includes a thin region having a thickness T satisfying $T < L$ where L is a length of each nozzle hole. The thin region includes a plurality of recesses formed in a region including a portion of the tip portion between each of a pair of nozzle holes adjacent each other in a circumferential direction of the tip portion; wherein each recess is shaped into a slit extending from an internal bottom surface or from an external tip surface of the tip portion in the extension direction of the precombustion-chamber central axis.

[0010] According to the above configuration, the tip portion of the precombustion-chamber forming portion has a thin region having a thickness T satisfying $T < L$, where L is the length of the nozzle hole. Since the tip portion has a plurality of nozzle holes, the thin region is formed around the nozzle holes. When such a thin region is formed around the nozzle holes of the tip portion, which are largely affected by heat of the combustion flame, it is possible to reduce the heat capacity and stiffness around the nozzle holes, and it is possible to flatten the temperature distribution (temperature difference) around the nozzle holes at temperature rise. Reducing the heat capacity and stiffness around the nozzle holes facilitates thermal deformation (thermal expansion and thermal contraction) around the nozzle holes, thus reducing thermal strain around the nozzle holes and thermal stress generated due to confinement of the thermal strain. Further, flattening the temperature distribution around the nozzle holes at temperature rise suppresses non-uniform thermal deformation around the nozzle holes, thus re-

ducing thermal strain around the nozzle holes and thermal stress generated due to confinement of the thermal strain. Consequently, it is possible to suppress the occurrence of crack around the nozzle holes due to heat fatigue.

[0011] A precombustion chamber gas engine according to a second aspect of the present invention comprises: a main-chamber forming portion forming a main combustion chamber; and a precombustion-chamber forming portion forming a precombustion chamber communicating with the main combustion chamber via a plurality of nozzle holes. The precombustion-chamber forming portion includes a cylindrical portion extending along an extension direction of a precombustion chamber central axis of the precombustion-chamber forming portion, and a tip portion closing a main-combustion-chamber-side end of the cylindrical portion and having the nozzle holes. The tip portion is located on a main combustion chamber side of a reference plane that extends in a direction perpendicular to the precombustion chamber central axis at a position away from an upper edge of a precombustion-chamber-side opening of each nozzle hole by a length predetermined times a diameter of each nozzle hole in a direction opposite to the main combustion chamber along the extension direction of the precombustion chamber central axis. The tip portion includes a thin region having a thickness T satisfying $T < T_0$ where T_0 is a thickness of the precombustion-chamber forming portion at the reference plane. The thin region includes a plurality of recesses formed in a region including a portion of the tip portion between each of a pair of nozzle holes adjacent each other in a circumferential direction of the tip portion; wherein each recess is shaped into a slit extending from an internal bottom surface or from an external tip surface of the tip portion in the extension direction of the precombustion-chamber central axis.

[0012] According to the above configuration, the tip portion of the precombustion-chamber forming portion is located on the main combustion chamber side of the reference plane that extends in a direction perpendicular to the precombustion chamber central axis at a position away from the upper edge of the precombustion-chamber-side opening of each nozzle hole by a length predetermined times, e.g., three times, the diameter of each nozzle hole in a direction opposite to the main combustion chamber along the extension direction of the precombustion chamber central axis. Further, the tip portion has a thin region having a thickness T satisfying $T < T_0$, where T_0 is the thickness of the precombustion-chamber forming portion at the reference plane. In other words, the thickness of the thin region is less than that at the reference plane which is less affected by the combustion flame. When such a thin region is formed around the nozzle holes of the tip portion, which are largely affected by heat of the combustion flame, it is possible to reduce the heat capacity and stiffness around the nozzle holes, and it is possible to flatten the temperature distribution (temperature difference) around the nozzle holes at tem-

perature rise. Reducing the heat capacity and stiffness around the nozzle holes facilitates thermal deformation (thermal expansion and thermal contraction) around the nozzle holes, thus reducing thermal strain around the nozzle holes and thermal stress generated due to confinement of the thermal strain. Further, flattening the temperature distribution around the nozzle holes at temperature rise suppresses non-uniform thermal deformation around the nozzle holes, thus reducing thermal strain around the nozzle holes and thermal stress generated due to confinement of the thermal strain. Consequently, it is possible to suppress the occurrence of crack around the nozzle holes due to heat fatigue.

[0013] In some embodiments according to the first aspect or second aspect, the thin region includes a tip of the tip portion.

[0014] With such configuration, since the thin region includes the tip of the tip portion, the thickness of the tip of the tip portion is reduced compared to when the thin region is not present in the tip of the tip portion. Thus, the heat capacity and stiffness around the nozzle holes are reduced, and the temperature distribution around the nozzle holes at temperature rise is flattened. As a result, it is possible to suppress the occurrence of crack around the nozzle holes due to heat fatigue.

[0015] In some embodiments according to the second aspect, the thin region includes at least a part of a peripheral edge of a main-combustion-side opening of each nozzle hole in the tip portion.

[0016] With such configuration, since the thin region includes at least a part of the peripheral edge of the main-combustion-chamber-side opening of the nozzle hole in the tip portion, the thickness around the nozzle holes is reduced. Thus, the heat capacity and stiffness around the nozzle holes are reduced, and the temperature distribution around the nozzle holes at temperature rise is flattened. As a result, it is possible to suppress the occurrence of crack around the nozzle holes due to heat fatigue.

[0017] In some embodiments, in any one of the above configurations, the thin region includes a portion of the tip portion between a pair of nozzle holes adjacent each other in a circumferential direction of the tip portion.

[0018] With such configuration, since the thin region includes a portion of the tip portion between a pair of nozzle holes adjacent in the circumferential direction of the tip portion, the thickness of the portion between the pair of circumferentially adjacent nozzle holes is reduced. Thus, the heat capacity and stiffness around the pair of nozzle holes are reduced, and the temperature distribution around the pair of nozzle holes at temperature rise is flattened. As a result, it is possible to suppress the occurrence of crack around the nozzle holes due to heat fatigue.

[0019] In some embodiments, in the above configuration, the thin region includes at least one outer recess formed in an outer peripheral surface of the tip portion facing the main combustion chamber.

[0020] According to such configuration, the thin region includes at least one outer recess formed in an outer peripheral surface of the tip portion facing the main combustion chamber. In other words, since the thin region is defined by the at least one outer recess formed in the outer peripheral surface of the tip portion, it is possible to reduce thermal strain around the main-combustion-chamber-side openings of the nozzle holes and thermal stress generated due to confinement of the thermal strain.

[0021] In an alternative embodiment of the above configuration, the thin region includes at least one inner recess formed in an inner peripheral surface of the tip portion facing the precombustion chamber.

[0022] According to such configuration, the thin region includes at least one inner recess formed in an inner peripheral surface of the tip portion facing the precombustion chamber. In other words, since the thin region is defined by the at least one inner recess formed in the inner peripheral surface of the tip portion, it is possible to reduce thermal strain around the precombustion-chamber-side openings of the nozzle holes and thermal stress generated due to confinement of the thermal strain.

Advantageous Effects

[0023] At least one embodiment of the present invention provides a precombustion chamber gas engine that can reduce thermal stress generated around the nozzle hole and suppress the occurrence of crack around the nozzle hole.

BRIEF DESCRIPTION OF DRAWINGS

[0024]

FIG. 1 is a schematic cross-sectional view of a precombustion chamber gas engine according to an example not being part of the present invention.

FIG. 2 is a schematic cross-sectional view of a precombustion-chamber forming portion according to an example (not being part of the invention).

FIG. 3 is a schematic cross-sectional view of a precombustion-chamber forming portion according to an embodiment for describing an outer recess formed in an outer peripheral surface of a tip portion facing a main combustion chamber.

FIG. 4 is a schematic cross-sectional view taken along line A-A in FIG. 3.

FIG. 5 is a schematic cross-sectional view of a precombustion-chamber forming portion according to another embodiment for describing a thin region formed in a tip portion.

FIG. 6 is a schematic cross-sectional view taken along line B-B in FIG. 5.

FIG. 7 is a schematic cross-sectional view of a precombustion-chamber forming portion according to another embodiment for describing an inner recess

formed in an inner peripheral surface of a tip portion facing a precombustion chamber.

FIG. 8 is a schematic cross-sectional view taken along line C-C in FIG. 7.

FIG. 9 is a schematic enlarged cross-sectional view of the vicinity of a tip portion of a precombustion-chamber forming portion according to another example (not part of the invention) for describing a chamfered shape formed on the edge of a precombustion-chamber-side opening of a nozzle hole.

FIG. 10 is a diagram for describing temperature analysis result and stress analysis result around a nozzle hole of a precombustion-chamber forming portion.

FIG. 11 is a table showing a dimensionless strain range of a precombustion-chamber-side opening of a precombustion-chamber forming portion having a first thin region, compared to a precombustion-chamber forming portion not having the thin region.

FIG. 12 is a table showing a dimensionless strain range of a precombustion-chamber-side opening of a precombustion-chamber forming portion having a first thin region, a third thin region, and a chamfered shape on the edge of the precombustion-chamber-side opening, compared to a precombustion-chamber forming portion not having the thin region.

FIG. 13 is a schematic cross-sectional view of a precombustion-chamber forming portion according to another example (not part of the invention).

30 DETAILED DESCRIPTION

[0025] Embodiments of the present invention will now be described in detail with reference to the accompanying drawings. It is intended, however, that unless particularly identified, dimensions, materials, shapes, relative positions and the like of components described in the embodiments shall be interpreted as illustrative only and not intended to limit the scope of the present invention.

[0026] For instance, an expression of relative or absolute arrangement such as "in a direction", "along a direction", "parallel", "orthogonal", "centered", "concentric" and "coaxial" shall not be construed as indicating only the arrangement in a strict literal sense, but also includes a state where the arrangement is relatively displaced by a tolerance, or by an angle or a distance whereby it is possible to achieve the same function.

[0027] For instance, an expression of an equal state such as "same", "equal" and "uniform" shall not be construed as indicating only the state in which the feature is strictly equal, but also includes a state in which there is a tolerance or a difference that can still achieve the same function.

[0028] Further, for instance, an expression of a shape such as a rectangular shape or a cylindrical shape shall not be construed as only the geometrically strict shape, but also includes a shape with unevenness or chamfered corners within the range in which the same effect can be achieved.

[0029] On the other hand, an expression such as "comprise", "include", "have", "contain" and "constitute" are not intended to be exclusive of other components.

[0030] FIG. 1 is a schematic cross-sectional view of a precombustion chamber gas engine according to an example (not part of the invention). As shown in FIG. 1, the precombustion chamber gas engine 1 according to some examples and embodiments includes a main-chamber forming portion 2 forming a main combustion chamber 20 (main chamber) of the engine, and a precombustion-chamber forming portion 3 forming a precombustion chamber 30 communicating with the main combustion chamber 20 via a plurality of nozzle holes 4.

[0031] As shown in FIG. 1, the precombustion chamber gas engine 1 includes: a cylinder 13 including a cylinder block 11 having therein a tubular structure of cylindrical shape and a cylinder head 12 having therein a recessed structure capable of capping the top of the tubular structure; a piston 14 reciprocally disposed within the cylinder 13; and a precombustion chamber cap 19 made of nickel-based alloy, for example. The main combustion chamber 20 is defined between the cylinder 13 and the piston 14. The precombustion chamber 30 is defined by the precombustion chamber cap 19 disposed on the cylinder head 12 so as to be positioned above the main combustion chamber 20 (on the opposite side from the piston 14). In other words, the cylinder 13 and the piston 14 form the main-chamber forming portion 2, and the precombustion chamber cap 19 forms the precombustion-chamber forming portion 3.

[0032] As shown in FIG. 1, the precombustion-chamber forming portion 3 includes a plurality of nozzle holes 4 connecting the precombustion chamber 30 formed in the precombustion-chamber forming portion 3 to the outside. The main combustion chamber 20 communicates with the precombustion chamber 30 via the plurality of nozzle holes 4.

[0033] Further, as shown in FIG. 1, the precombustion-chamber forming portion 3 includes a small-diameter-cylinder forming portion 31 which forms a small-diameter cylinder chamber 310 of cylindrical shape having a predetermined inner diameter and connected to the plurality of nozzle holes 4 and a large-diameter-cylinder forming portion 32 which forms a large-diameter cylinder chamber 320 of cylindrical shape having an inner diameter larger than that of the small-diameter cylinder chamber 310. That is, the precombustion chamber 30 includes the small-diameter cylinder chamber 310 and the large-diameter cylinder chamber 320. The precombustion chamber 30 may have other shape, for example, a cylindrical shape having a constant inner diameter.

[0034] As shown in FIG. 1, the precombustion chamber central axis CS coincides with the central axis of the small-diameter cylinder chamber 310. Although in the example shown in FIG. 1, the main chamber central axis CM coincides with the precombustion chamber central axis CS, the precombustion chamber central axis CS may be inclined with respect to the main chamber central

axis CM. Further, the central axis of the small-diameter cylinder chamber 310 may not coincide with the central axis of the large-diameter cylinder chamber 320.

[0035] In the example shown in FIG. 1, the precombustion chamber gas engine 1 further includes an ignition device 6 disposed in the large-diameter cylinder chamber 320 of the precombustion chamber 30, and a precombustion-chamber-gas supply device 7 for directly supplying a precombustion chamber fuel gas to the precombustion chamber 30 not via the main combustion chamber 20. The ignition device 6 has an ignition portion 61 capable of igniting an air-fuel mixture. As shown in FIG. 1, the ignition device 6 is an ignition plug, and the ignition device 6 is mounted on the engine so that an electrode (ignition portion 61) of the ignition plug is positioned on the precombustion chamber central axis CS. The ignition device 6 may be disposed such that the ignition portion 61 is at a predetermined distance from the precombustion chamber central axis CS. As shown in FIG. 1, the precombustion-chamber-gas supply device 7 is configured to supply a precombustion chamber fuel gas to the large-diameter cylinder chamber 320, and the supply of the precombustion chamber fuel gas to the precombustion chamber 30 is controlled by a precombustion-chamber-fuel-gas supply valve 71.

[0036] In the example shown in FIG. 1, the precombustion chamber gas engine 1 further includes an intake port 15 and an exhaust port 16 connected around the cylinder head 12; an intake valve 17 for opening and closing the intake port 15; and an exhaust valve 18 for opening and closing the exhaust port 16.

[0037] The precombustion chamber gas engine 1 having the above configuration opens the intake valve 17 and closes the exhaust valve 18 when the piston 14 moves downward in the intake stroke, for instance. As the intake valve 17 opens, a lean premixed gas containing fuel gas and air is introduced into the cylinder 13 through the intake port 15 connected to the intake valve 17. Further, as the precombustion-chamber-fuel-gas supply valve 71 opens, the precombustion chamber fuel gas is introduced into the precombustion chamber 30. Meanwhile, in the compression stroke, the precombustion-chamber-fuel-gas supply valve 71 closes when the piston 14 moves upward. Further, the lean premixed gas introduced into the cylinder 13 through the intake port 15 is compressed as the piston 14 moves upward, and a part of the lean premixed gas is introduced into the precombustion chamber 30 through each of the nozzle holes 4 of the precombustion chamber 30. In the combustion stroke, the lean premixed gas introduced from the main combustion chamber 20 to the precombustion chamber 30 is mixed with the precombustion chamber fuel gas to produce an air-fuel mixture having a concentration suitable for ignition in the precombustion chamber 30. The air-fuel mixture in the precombustion chamber 30 is ignited by the ignition device 6 at a predetermined timing when the piston 14 arrives at the vicinity of the compression top dead center, so that the air-fuel mixture in the

precombustion chamber 30 is combusted. Combustion flames generated by this combustion is injected into the cylinder 13 through each of the nozzle holes and ignite the lean premixed gas in the cylinder 13, which leads to combustion of the lean premixed gas in the main combustion chamber 20.

[0038] In the precombustion chamber gas engine 1, for example, in the combustion stroke, rapid temperature change occurs in the inner wall of the precombustion-chamber forming portion 3 and the nozzle holes 4, such as rapid temperature increase of the inner wall of the precombustion-chamber forming portion 3 and the nozzle holes 4 when the combustion flames are injected into the cylinder 13 from the nozzle holes 4, which may cause a crack in the inner wall of the precombustion-chamber forming portion 3 and the nozzle holes 4. The present inventors have found that, as described later, when the precombustion-chamber forming portion 3 has a thin region 5 or a thin region 8 to reduce the heat capacity and stiffness around the nozzle holes 4 and to flatten the temperature distribution (temperature difference) around the nozzle holes, it is possible to reduce thermal stress around the nozzle holes 4, and suppress the occurrence of crack around the nozzle holes 4.

[0039] Hereinafter, a configuration of the precombustion-chamber forming portion 3 of the precombustion chamber gas engine 1 will be described.

[0040] FIGs. 2, 3, 5, and 7 are each a schematic cross-sectional view of a precombustion-chamber forming portion according to an embodiment or an example. FIG. 3 is a diagram for describing an outer recess formed in an outer peripheral surface of a tip portion facing a main combustion chamber. FIG. 4 is a schematic cross-sectional view taken along line A-A in FIG. 3. FIG. 5 is a diagram for describing a thin region formed in a tip portion. FIG. 6 is a schematic cross-sectional view taken along line B-B in FIG. 5. FIG. 7 is a diagram for describing an inner recess formed in an inner peripheral surface of a tip portion facing a precombustion chamber. FIG. 8 is a schematic cross-sectional view taken along line C-C in FIG. 7. The line A-A in FIG. 3, the line B-B in FIG. 5, and the line C-C in FIG. 7 pass through an upper edge 411 of a precombustion-chamber-side opening 41 of the nozzle hole 4 and extend in a direction perpendicular to the precombustion chamber central axis CS.

[0041] As shown in FIGs. 2, 3, 5, and 7, the precombustion-chamber forming portion 3 of the precombustion chamber gas engine 1 according to some embodiments includes a cylindrical portion 34 extending along the extension direction (vertical direction in the figures) of the precombustion chamber central axis CS of the precombustion-chamber forming portion 3, and a tip portion 33 closing one end (lower end) of the cylindrical portion 34 closer to the main combustion chamber 20. As shown in FIGs. 2, 3, 5, and 7, the cylindrical portion 34 includes a small-diameter cylindrical portion 341 of cylindrical shape and a large-diameter cylindrical portion 342 of cylindrical shape having a larger outer diameter than the

small-diameter cylindrical portion 341. A stepped surface 343 is formed between an outer peripheral surface 344 of the small-diameter cylindrical portion 341 and an outer peripheral surface 345 of the large-diameter cylindrical portion 342. The stepped surface 343 of the cylindrical portion 34 abuts on an unillustrated portion of the cylinder head 12, or is in contact with the cylinder head 12 via an unillustrated component such as a seal member so that the precombustion-chamber forming portion 3 is supported by the cylinder head 12. Further, the large-diameter cylindrical chamber 320 of the precombustion-chamber forming portion 3 is formed in cylindrical shape having a constant internal diameter, and a stepped surface 322 is formed between a wall surface 321 of the large-diameter cylindrical chamber 320 and a wall surface 312 of the small-diameter cylinder chamber 310.

[0042] As shown in FIGs. 2, 3, 5, and 7, the tip portion 33 has a plurality of nozzle holes 4 whose central axes CP are inclined with respect to the precombustion chamber central axis CS. As shown in FIGs. 2, 3, 5, and 7, D represents the nozzle hole diameter, and L represents the nozzle hole length of the nozzle hole 4. The nozzle hole diameter D and the nozzle hole length L are determined by the combustion performance of the precombustion chamber gas engine 1 and the internal pressure of the precombustion-chamber forming portion 3. The nozzle holes 4 are arranged at intervals in the circumferential direction, as shown in FIGs. 4, 6, and 8.

[0043] As shown in FIGs. 2, 3, 5, and 7, the tip portion 33 is formed integrally with a lower end of the small-diameter cylindrical portion 341 opposite to an upper end that is formed integrally with the large-diameter cylindrical portion 342. As shown in FIGs. 2, 3, 5, and 7, the tip portion 33 protrudes from the lower end of the small-diameter cylindrical portion 341 and has a convex tip surface 332. Alternatively, the tip portion 33 may be recessed inward from the lower end of the small-diameter cylindrical portion 341 and has a concave tip surface. Alternatively, the tip portion 33 may be formed so as to extend along a direction perpendicular to the extension direction of the precombustion chamber central axis CS and has a flat tip surface.

[0044] As shown in FIGs. 2, 4 to 6, and 8, the tip portion 33 has a thin region 5 having a thickness T satisfying $T < L$, where L is the length of the nozzle hole 4.

[0045] According to the above configuration, the tip portion 33 of the precombustion-chamber forming portion 3 has the thin region 5 having a thickness T satisfying $T < L$, where L is the length of the nozzle hole 4. Since the tip portion 33 has the plurality of nozzle holes 4, the thin region 5 is formed around the nozzle holes 4. When such a thin region 5 is formed around the nozzle holes 4 of the tip portion 33, which are largely affected by heat of the combustion flame, it is possible to reduce the heat capacity and stiffness around the nozzle holes 4, and it is possible to flatten the temperature distribution (temperature difference) around the nozzle holes 4 at temperature rise. Reducing the heat capacity and stiffness around

the nozzle holes 4 facilitates thermal deformation (thermal expansion and thermal contraction) around the nozzle holes 4, thus reducing thermal strain around the nozzle holes 4 and thermal stress generated due to confinement of the thermal strain. Further, flattening the temperature distribution around the nozzle holes 4 at temperature rise suppresses non-uniform thermal deformation around the nozzle holes 4, thus reducing thermal strain around the nozzle holes 4 and thermal stress generated due to confinement of the thermal strain. Consequently, it is possible to suppress the occurrence of crack around the nozzle holes 4 due to heat fatigue.

[0046] In some embodiments and examples, as shown in FIGs. 2 and 5, the thin region 5 includes a tip 331 of the tip portion 33. As shown in FIGs. 2 and 5, the tip 331 of the tip portion 33 is an end opposite to an end integrally connected with the cylindrical portion 34 with respect to the extension direction of the precombustion chamber central axis CS.

[0047] In the example shown in FIG. 2 and in the embodiment shown in FIG. 5, the precombustion-chamber forming portion 3 includes a precombustion-chamber forming portion 3A, 3C having the thin region 5 including a first thin region 51. As shown in FIGs. 2 and 5, the tip portion 33 of the precombustion-chamber forming portion 3A, 3C has a thickness gradually decreasing toward the tip 331 in a region from a lower edge 422 of a main-combustion-chamber-side opening 42 of the nozzle hole 4 to the tip 331 in the extension direction of the precombustion chamber central axis CS. In the vicinity of the tip 331 of the tip portion 33 of the precombustion-chamber forming portion 3A, 3C, a tip surface 332 is formed which has a smaller curvature than an outer peripheral surface 333 forming an outer periphery of a portion whose thickness is equal to the nozzle hole length L. Accordingly, the thickness T of a portion where the tip surface 332 of the tip portion 33 forms the outer periphery is smaller than the nozzle hole length L of the nozzle hole 4. As shown in FIGs. 2 and 5, the first thin region 51 is formed from the tip 331 to a lower side of a lower edge 412 of the precombustion-chamber-side opening 41 in the extension direction of the precombustion chamber central axis CS. The first thin region 51 does not include the peripheral edge of the nozzle hole 4, i.e., the precombustion-chamber-side opening 41 and the main-combustion-chamber-side opening 42 of the nozzle hole 4.

[0048] With the above configuration, since the thin region 5 (first thin region 51) includes the tip 331 of the tip portion 33, the thickness of the tip 331 of the tip portion 33 is reduced compared to when the thin region 5 is not present in the tip 331 of the tip portion 33. Thus, the heat capacity and stiffness around the nozzle holes 4 are reduced, and the temperature distribution around the nozzle holes 4 at temperature rise is flattened. As a result, it is possible to suppress the occurrence of crack around the nozzle holes 4 due to heat fatigue. Incidentally, the thin region 5 including the tip 331 of the tip portion 33 can be easily formed in the precombustion-chamber

forming portion 3 having no thin region 5 in the tip 331 of the tip portion 33, by cutting or the like.

[0049] In some embodiments, as shown in FIGs. 4, 6, and 8, the thin region 5 (second thin region 52, third thin region 53) includes a portion of the tip portion 33 between a pair of nozzle holes 4 adjacent in the circumferential direction of the tip portion 33. In the embodiments shown in FIGs. 2 to 8, the thickness T1 of a part of the precombustion-chamber forming portion 3 in the circumferential direction in a plane passing through the upper edge 411 of the precombustion-chamber-side opening 41 of the nozzle hole 4 and extending in a direction perpendicular to the precombustion chamber central axis CS is equal to the nozzle hole length L of the nozzle hole 4. In the embodiment shown in FIGs. 3 and 4, the precombustion-chamber forming portion 3 includes a precombustion-chamber forming portion 3B having the thin region 5 including a second thin region 52. In the embodiment shown in FIGs. 5 and 6, the precombustion-chamber forming portion 3C has the thin region 5 including, in addition to the first thin region 51 described above, the second thin region 52. As shown in FIGs. 4 and 6, the second thin region 52 is formed in the tip portion 33 between each pair of nozzle holes 4 adjacent in the circumferential direction of the tip portion 33. In the embodiment shown in FIGs. 7 and 8, the precombustion-chamber forming portion 3 includes a precombustion-chamber forming portion 3D having the thin region 5 including a third thin region 53. As shown in FIGs. 7 and 8, the third thin region 53 is formed in the tip portion 33 between each pair of nozzle holes 4 adjacent in the circumferential direction of the tip portion 33.

[0050] With the above configuration, since the thin region 5 (second thin region 52, third thin region 53) includes a portion of the tip portion 33 between a pair of nozzle holes 4 adjacent in the circumferential direction of the tip portion 33, the thickness of the portion between the pair of circumferentially adjacent nozzle holes 4 is reduced. Thus, the heat capacity and stiffness around the pair of nozzle holes 4 are reduced, and the temperature distribution around the pair of nozzle holes 4 at temperature rise is flattened. As a result, it is possible to suppress the occurrence of crack around the nozzle holes 4 due to heat fatigue.

[0051] In some embodiments, as shown in FIGs. 4 and 6, the second thin region 52 includes at least one outer recess 36, 37 (recess 35) formed in an outer peripheral surface (tip surface 332, outer peripheral surface 333) of the tip portion 33 facing the main combustion chamber 20. As shown in FIGs. 3 and 5, the outer recess 36, 37 is formed at least from the lower edge 422 of the main-combustion-chamber-side opening 42 to the upper edge 411 of the precombustion-chamber-side opening 41 in the extension direction of the precombustion chamber central axis CS. In the embodiments shown in FIGs. 4 and 6, a plurality of outer recesses 36, 37 are formed in the tip portion 33. The outer recesses 36, 37 are arranged at intervals in the circumferential direction of the tip por-

tion 33, one between each pair of nozzle holes 4 adjacent in the circumferential direction of the tip portion 33.

[0052] In the embodiment shown in FIGs. 3 and 4, the precombustion-chamber forming portion 3B has a constant thickness in portions, not provided with the outer recess 36, of the tip portion 33 and the cylindrical portion 34 from the stepped surface 343 to the tip portion 33 in the extension direction of the precombustion chamber central axis CS. As shown in FIG. 3, each outer recess 36 is shaped into a slit extending from the tip surface 332 of the tip portion 33 to the stepped surface 343 of the cylindrical portion 34 in the extension direction of the precombustion chamber central axis CS. The outer recesses 36 are recessed from the tip surface 332 of the tip portion 33 and the outer peripheral surface 344 of the small-diameter cylindrical portion 341 so as to have arc-shaped bottom surfaces on the inner side (a side facing the precombustion chamber 30). Accordingly, as shown in FIG. 4, the thickness T of a part of the tip portion 33 in the circumferential direction provided with the outer recess 36 is less than the thickness T1 of a remaining part in the circumferential direction not provided with the outer recess 36. Here, the thickness T1 is equal to the nozzle hole length L of the nozzle hole 4, as described above.

[0053] In the embodiment shown in FIGs. 5 and 6, the precombustion-chamber forming portion 3C has a constant thickness in portions, not provided with the outer recess 37, of the cylindrical portion 34 from the stepped surface 343 to the tip portion 33 in the extension direction of the precombustion chamber central axis CS and of the tip portion 33 including the lower edge 422 of the main-combustion-chamber-side opening 42 of the nozzle hole 4 and adjacent to the cylindrical portion 34. As shown in FIG. 5, each outer recess 37 is shaped into a slit extending from the tip surface 332 of the tip portion 33 to the lower end of the small-diameter cylindrical portion 341 in the extension direction of the precombustion chamber central axis CS. The outer recesses 37 are recessed from the outer peripheral surface 333 of the tip portion 33 and the outer peripheral surface 344 of the small-diameter cylindrical portion 341 so as to have a contact depth and an arc-shaped bottom surface on the inner side (a side facing the precombustion chamber 30). Accordingly, as shown in FIG. 6, the thickness T of a part of the tip portion 33 in the circumferential direction provided with the outer recess 37 is less than the thickness T1 of a remaining part in the circumferential direction not provided with the outer recess 37. Here, the thickness T1 is equal to the nozzle hole length L of the nozzle hole 4 as described above.

[0054] According to the above configuration, the thin region 5 (second thin region 52) includes at least one outer recess 36, 37 formed in an outer peripheral surface (tip surface 332, outer peripheral surface 333) of the tip portion 33 facing the main combustion chamber 20. In other words, since the thin region 5 is defined by the at least one outer recess 36, 37 formed in the outer peripheral surface of the tip portion 33, it is possible to reduce

thermal strain around the main-combustion-chamber-side openings 42 of the nozzle holes 4 and thermal stress generated due to confinement of the thermal strain. Incidentally, the outer recess 36, 37 can be easily formed in the outer peripheral surface of the tip portion 33, by cutting or the like.

[0055] In some embodiments, as shown in FIGs. 7 and 8, the third thin region 53 includes at least one inner recess 38 (recess 35) formed in an inner peripheral surface (bottom surface 311, wall surface 312) of the tip portion 33 facing the precombustion chamber 30. As shown in FIG. 7, the inner recess 38 is formed at least from the lower edge 422 of the main-combustion-chamber-side opening 42 to the upper edge 411 of the precombustion-chamber-side opening 41 in the extension direction of the precombustion chamber central axis CS. In the embodiment shown in FIG. 8, a plurality of inner recesses 38 are formed in the tip portion 33. The inner recesses 38 are arranged at intervals in the circumferential direction of the tip portion 33, one between each pair of nozzle holes 4 adjacent in the circumferential direction of the tip portion 33.

[0056] In the embodiment shown in FIGs. 7 and 8, the precombustion-chamber forming portion 3D has a constant thickness in a portion, not provided with the inner recess 38, of the tip portion 33 and of the cylindrical portion 34 from the stepped surface 343 to the tip portion 33 in the extension direction of the precombustion chamber central axis CS. As shown in FIG. 7, each inner recess 38 is shaped into a slit extending from the bottom surface 311 of the small-diameter cylinder chamber 310 to the stepped surface 322 of the large-diameter cylinder chamber 320 in the extension direction of the precombustion chamber central axis CS. The inner recesses 38 are recessed from the bottom surface 311 and the wall surface 312 of the small-diameter cylinder chamber 310 so as to have a contact depth and an arc-shaped bottom surface on the inner side (a side facing the main combustion chamber 20). As shown in FIG. 8, the inner recesses 38 are connected to each other at the bottom surface 311 of the small-diameter cylinder chamber 310. Accordingly, as shown in FIG. 8, the thickness T of a part of the tip portion 33 in the circumferential direction provided with the inner recess 38 is less than the thickness T1 of a remaining part in the circumferential direction not provided with the inner recess 38. Here, the thickness T1 is equal to the nozzle hole length L of the nozzle hole 4 as described above.

[0057] According to the above configuration, the thin region 5 (third thin region 53) includes at least one inner recess 38 formed in an inner peripheral surface (bottom surface 311, wall surface 312) of the tip portion 33 facing the precombustion chamber 30. In other words, since the thin region 5 is defined by the at least one inner recess 38 formed in the inner peripheral surface of the tip portion 33, it is possible to reduce thermal strain around the precombustion-chamber-side openings 41 of the nozzle holes 4 and thermal stress generated due to confinement

of the thermal strain. When the inner recess 38 is formed to the stepped surface 343 of the cylindrical portion 34 in the extension direction of the precombustion chamber central axis CS, the inner recess 38 can be easily formed on the inner side of the tip portion 33 by cutting or the like.

[0058] In the above embodiments, as shown in FIGs. 3 and 7, the recess 35 (outer recesses 36, 37, inner recesses 38) extends from the tip portion 33 over at least a part of the cylindrical portion 34 across the reference plane RP along the extension direction of the precombustion chamber central axis CS.

[0059] With the above configuration, since the recess 35 extends from the tip portion 33 over at least a part of the cylindrical portion 34 along the extension direction of the precombustion chamber central axis CS, the at least part of the cylindrical portion 34 adjacent to the tip portion 33 has a reduced thickness. As a result, the at least part of the cylindrical portion 34 adjacent to the tip portion 33 can be easily deformed by heat, so that heat in the tip portion 33 easily transfers to the cylindrical portion 34. Thus, it is possible to reduce thermal strain around the nozzle holes and thermal stress generated due to confinement of the thermal strain.

[0060] FIG. 9 is a schematic enlarged cross-sectional view of the vicinity of a tip portion of a precombustion-chamber forming portion according to another example for describing a chamfered shape formed on the edge of a precombustion-chamber-side opening of a nozzle hole. In the example shown in FIG. 9, the precombustion-chamber forming portion 3 includes a precombustion-chamber forming portion 3E having a chamfered portion 414 on the precombustion-chamber-side opening 4. As shown in FIG. 9, the precombustion-chamber forming portion 3E has the same configuration as the precombustion-chamber forming portion 3C except that the chamfered portion 414 of C-chamfer plane is formed over the entire peripheral edge of the precombustion-chamber-side opening 41. The chamfered portion 414 may be formed on the precombustion-chamber-side opening 41 of the precombustion-chamber forming portion 3A, 3B, 3D, and 3G described later. Further, the chamfered portion may be formed over the entire periphery of the main-combustion-chamber-side opening 42. With the above configuration, since the precombustion-chamber forming portion 3E has the chamfered portion 414 on the precombustion-chamber-side opening 41, the temperature of the portion forming the precombustion-chamber-side opening 41 is reduced compared to when the chamfered portion 414 is not provided. Thus, it is possible to reduce thermal strain around the precombustion-chamber-side openings 41 of the nozzle holes 4 and thermal stress generated due to confinement of the thermal strain.

(Temperature analysis result and stress analysis result)

[0061] Stress analysis was performed on the basis of temperature analysis and temperature analysis results for the precombustion-chamber forming portion 3 of the

precombustion chamber gas engine 1 according to the above embodiments. Details will be described. Temperature analysis was performed with varying thermal conditions, e.g., varying atmosphere temperature and heat transfer coefficient during engine operation, according to each surface such as the tip surface 332 and the outer peripheral surface 333 of the tip portion 33 of the precombustion-chamber forming portion 3 (precombustion chamber cap 19) disposed on the cylinder head 12, the stepped surface 343 and the outer peripheral surface 344 of the cylindrical portion 34, and the bottom surface 311 and the wall surface 312 of the small-diameter cylinder chamber 310, to estimate the temperature change of the precombustion-chamber forming portion 3.

[0062] FIG. 10 is a diagram for describing temperature analysis result and stress analysis result around a nozzle hole of a precombustion-chamber forming portion. As a result of the temperature analysis, the temperature of the precombustion-chamber-side opening 41 of the nozzle hole 4 shown in FIG. 10 more rapidly changed than the other part of the precombustion-chamber forming portion 3 and was raised to higher temperature than the other part of the precombustion-chamber forming portion 3. On the basis of this temperature analysis result, stress analysis was performed to estimate strain change and calculate a strain range at each of measurement points P1 to P3. The measurement point P1 is located on the upper edge 411 of the precombustion-chamber-side opening 41, and the measurement point P3 is located on the lower edge 412 of the precombustion-chamber-side opening 41. The measurement point P2 is located on an intermediate edge 413 between the upper edge 411 and the lower edge 412 of the precombustion-chamber-side opening 41 in the extension direction of the precombustion chamber central axis CS. If the precombustion-chamber-side opening 41 has the chamfered portion 414 as described above, as shown in FIG. 9, the upper edge 411, the lower edge 412, and the intermediate edge 413 are disposed on the peripheral edge of the chamfered portion 414 closer to the main combustion chamber 20.

[0063] FIG. 11 is a table showing a dimensionless strain range of a precombustion-chamber-side opening of a precombustion-chamber forming portion having a first thin region, compared to a precombustion-chamber forming portion not having the thin region. FIG. 12 is a table showing a dimensionless strain range of a precombustion-chamber-side opening of a precombustion-chamber forming portion having a first thin region, a second thin region, and a chamfered shape on the edge of a precombustion-chamber-side opening, compared to a precombustion-chamber forming portion not having the thin region. 3F in FIGs. 11 and 12 is a precombustion-chamber forming portion having a tip as shown by the two-dot chain line in FIG. 2 and not having the thin region 5.

[0064] In FIG. 11, strain ranges of the precombustion-chamber forming portion 3F and the precombustion-chamber forming portion 3A at each measurement point

P1 to P3 are expressed dimensionlessly as the ratio when the strain range of the precombustion-chamber forming portion 3F is 1, and the reduction rate of the precombustion-chamber forming portion 3A with respect to the precombustion-chamber forming portion 3F is shown. As shown in FIG. 11, the precombustion-chamber forming portion 3A having the first thin region 51 has a reduced strain range at the measurement point P2, compared to the precombustion-chamber forming portion 3F. Thus, the precombustion-chamber forming portion 3A can suppress the occurrence of crack generated between a pair of circumferentially adjacent nozzle holes 4, compared to the precombustion-chamber forming portion 3F.

[0065] In FIG. 12, strain ranges of the precombustion-chamber forming portion 3F and the precombustion-chamber forming portion 3E at each measurement point P1 to P3 are expressed dimensionlessly as the ratio when the strain range of the precombustion-chamber forming portion 3F is 1, and the reduction rate of the precombustion-chamber forming portion 3E with respect to the precombustion-chamber forming portion 3F is shown. As shown in FIG. 12, the precombustion-chamber forming portion 3E having the first thin region 51, the second thin region 52, and the chamfered portion 414 on the precombustion-chamber-side opening 41 has reduced strain ranges at all measurement points P1 to P3, compared to the precombustion-chamber forming portion 3F. Further, the precombustion-chamber forming portion 3E has a larger reduction rate with respect to the precombustion-chamber forming portion 3F than the precombustion-chamber forming portion 3A shown in FIG. 11. Thus, the precombustion-chamber forming portion 3E can reduce thermal stress generated around the nozzle holes 4 and suppress the occurrence of crack, compared to the precombustion-chamber forming portions 3A and 3F.

[0066] Although in the above embodiments, the tip portion 33 has the thin region 5 having a thickness T satisfies $T < L$, in the following embodiments, the tip portion 33 has a thin region 8 having a thickness T satisfies $T < T_0$. Details will be described.

[0067] As shown in FIGs. 2, 3, 5, 7, and 13, the precombustion-chamber forming portion 3 of the precombustion chamber gas engine 1 according to some embodiments includes the cylindrical portion 34 extending along the extension direction (vertical direction in the figures) of the precombustion chamber central axis CS of precombustion-chamber forming portion 3, and the tip portion 33 closing one end (lower end) of the cylindrical portion 34 closer to the main combustion chamber 20. FIG. 13 is a schematic cross-sectional view of a precombustion-chamber forming portion according to another embodiment.

[0068] As shown in FIGs. 2, 3, 5, 7, and 13, the reference plane RP passes through a position 346 away from the upper edge 411 of the precombustion-chamber-side opening 41 of the nozzle hole 4 by a reference length RL in a direction opposite to the main combustion chamber 20 (lower side in the figures) along the extension direction

of the precombustion chamber central axis CS and extends in a direction perpendicular to the precombustion chamber central axis CS. The reference length RL is three times (predetermined times) the nozzle hole diameter D of the nozzle hole 4. As shown in FIGs. 2, 3, 5, 7 and 13, the tip portion 33 is located on the main combustion chamber 20 side of the reference plane RP. In other words, the reference plane RP is away from the nozzle hole 4 and thus is less affected by heat of the combustion flame. In contrast, the tip portion 33 located closer to the main combustion chamber 20 than the reference plane RP is greatly affected by heat of the combustion flame. Accordingly, the provision of the thin region 8 is more effective in the tip portion 33 than in the cylindrical portion 34.

[0069] As shown in FIGs. 2, 4 to 6, 8, 9, and 13, the tip portion 33 has the thin region 8 having a thickness T satisfying $T < T_0$, where T_0 is the thickness of the precombustion-chamber forming portion 3 at the reference plane RP. In the embodiments and examples shown in FIGs. 2 to 9, a portion of the precombustion-chamber forming portion 3 between the reference plane RP and a plane passing through the upper edge 411 of the precombustion-chamber-side opening 41 of the nozzle hole 4 and extending in a direction perpendicular to the precombustion chamber central axis CS has a cylindrical shape with a constant cross-sectional shape along a direction perpendicular to the precombustion chamber central axis CS. Accordingly, the thickness T_1 of a part of the tip portion 33 in the circumferential direction in a cross-section passing through the upper edge 411 of the precombustion-chamber-side opening 41 of the nozzle hole 4 and extending in a direction perpendicular to the precombustion chamber central axis CS is equal to the thickness T_0 at the reference plane RP. In the embodiments and examples shown in FIGs. 2 to 9, as described above, the thickness T_1 is equal to the nozzle hole length L of the nozzle hole 4. Although in the embodiments and examples shown in FIGs. 3 to 9, the thickness is not constant in the circumferential direction, in this case, the maximum thickness in the circumferential direction is the thickness T_0 or the thickness T_1 .

[0070] In the embodiments and examples shown in FIGs. 2, 5, and 9, the thin region 8 includes a first thin region 81 that is identical to the first thin region 51 of the thin region 5. In the embodiments shown in FIGs. 4 and 6, the thin region 8 includes a second thin region 82 that is identical to the second thin region 52 of the thin region 5. Accordingly, the second thin region 82 includes a portion of the tip portion 33 between a pair of nozzle holes 4 adjacent in the circumferential direction of the tip portion 33. Further, the second thin region 82 includes at least one outer recess 36, 37 formed in an outer peripheral surface (tip surface 332, outer peripheral surface 333) of the tip portion 33 facing the main combustion chamber 20. In the embodiment shown in FIG. 8, the thin region 8 includes a third thin region 83 that is identical to the third thin region 53 of the thin region 5. Accordingly, the

third thin region 83 includes a portion of the tip portion 33 between a pair of nozzle holes 4 adjacent in the circumferential direction of the tip portion 33. Further, the third thin region 83 includes at least one inner recess 38 (recess 35) formed in an inner peripheral surface (bottom surface 311, wall surface 312) of the tip portion 33 facing the precombustion chamber 30.

[0071] In the embodiment shown in FIG. 13, the precombustion-chamber forming portion 3 includes a precombustion-chamber forming portion 3G having the thin region 8 including a fourth thin region 84. As shown in FIG. 13, the tip portion 33 of the precombustion-chamber forming portion 3G has a thickness gradually decreasing toward the tip 331 in a region from the upper edge 421 of the main-combustion-chamber-side opening 42 of the nozzle hole 4 to the cylindrical portion 34 in the extension direction of the precombustion chamber central axis CS and a constant thickness equal to the nozzle hole length L1 in a region from the upper edge 421 to the tip 331. Thus, the thickness T of the tip portion 33 is less than the thickness T0 at the reference plane RP. As shown in FIG. 13, the fourth thin region 84 is formed from the tip 331 to an upper side of the upper edge 421 of the main-combustion-chamber-side opening 42 in the extension direction of the precombustion chamber central axis CS.

[0072] According to the above configuration, the tip portion 33 of the precombustion-chamber forming portion 3 is located on the main combustion chamber 20 side of the reference plane RP passing through a position 346 away from the upper edge 411 of the precombustion-chamber-side opening 41 of the nozzle hole 4 by a reference length RL, i.e., by a length three times (predetermined times) the nozzle hole diameter D of the nozzle hole 4, in a direction opposite to the main combustion chamber 20 along the extension direction of the precombustion chamber central axis CS and extending in a direction perpendicular to the precombustion chamber central axis CS. Further, the tip portion 33 has the thin region 8 having a thickness T satisfying $T < T_0$, where T0 is the thickness of the precombustion-chamber forming portion 3 at the reference plane RP. In other words, the thickness T of the thin region 8 is less than that at the reference plane RP which is less affected by the combustion flame. When such a thin region 8 is formed around the nozzle holes 4 of the tip portion 33, which are largely affected by heat of the combustion flame, it is possible to reduce the heat capacity and stiffness around the nozzle holes 4, and it is possible to flatten the temperature distribution (temperature difference) around the nozzle holes 4 at temperature rise. Reducing the heat capacity and stiffness around the nozzle holes 4 facilitates thermal deformation (thermal expansion and thermal contraction) around the nozzle holes 4, thus reducing thermal strain around the nozzle holes 4 and thermal stress generated due to confinement of the thermal strain. Further, flattening the temperature distribution around the nozzle holes 4 at temperature rise suppresses non-uniform thermal deformation around the nozzle

holes 4, thus reducing thermal strain around the nozzle holes 4 and thermal stress generated due to confinement of the thermal strain. Consequently, it is possible to suppress the occurrence of crack around the nozzle holes 4 due to heat fatigue.

[0073] In some embodiments and examples, as shown in FIGs. 2, 5, and 13, the thin region 8 (first thin region 81, fourth thin region 84) includes the tip 331.

[0074] With the above configuration, since the thin region 8 (first thin region 81, fourth thin region 84) includes the tip 331 of the tip portion 33, the thickness of the tip 331 of the tip portion 33 is reduced compared to when the thin region 8 is not present in the tip 331 of the tip portion 33. Thus, the heat capacity and stiffness around the nozzle holes 4 are reduced, and the temperature distribution around the nozzle holes 4 at temperature rise is flattened. As a result, it is possible to suppress the occurrence of crack around the nozzle holes 4 due to heat fatigue. Incidentally, the thin region 8 including the tip 331 of the tip portion 33 can be easily formed in the precombustion-chamber forming portion 3 having no thin region 8 in the tip 331 of the tip portion 33, by cutting or the like.

[0075] In some examples, as shown in FIG. 13, the thin region 8 (fourth thin region 84) includes at least a part of the peripheral edge of the main-combustion-chamber-side opening 42 of the nozzle hole 4 in the tip portion 33. Here, the peripheral edge of the main-combustion-chamber-side opening 42 includes the upper edge 421 and the lower edge 422 as shown in FIG. 13. In this case, since the nozzle hole length L1 of the nozzle hole 4 is shorter than the nozzle hole length L, the thickness of a portion of the tip portion 33 forming the inner periphery of the nozzle hole 4 is reduced. In the example shown in FIG. 13, the fourth thin region 84 includes both the upper edge 421 and the lower edge 422 of the main-combustion-chamber-side opening 42 of the nozzle hole 4.

[0076] With the above configuration, since the thin region 8 (fourth thin region 84) includes at least a part of the peripheral edge of the main-combustion-chamber-side opening 42 of the nozzle hole 4 in the tip portion 33, the thickness around the nozzle holes 4 is reduced. Thus, the heat capacity and stiffness around the nozzle holes 4 are reduced, and the temperature distribution around the nozzle holes 4 at temperature rise is flattened. As a result, it is possible to suppress the occurrence of crack around the nozzle holes 4 due to heat fatigue.

[0077] Although in the above embodiments and examples, as shown in FIGs. 2, 3, 5, 7, and 13, the reference length RL between the upper edge 411 and the position 346 is three times (predetermined times) the nozzle hole diameter D of the nozzle hole 4, the reference length RL may be longer or shorter than three times the nozzle hole diameter D, for example, equal to or twice the nozzle hole diameter D of the nozzle hole 4. Alternatively, the reference length RL may be zero. When the reference length RL is shortened or zero, the reference plane RP may be

disposed in a position according to the reference length RL. When the reference length is shortened, the range of the tip portion 33 is reduced, so that the thin region 8 is formed around the nozzle holes 4. Thus, it is possible to reduce thermal strain around the nozzle holes 4 and thermal stress generated due to confinement of the thermal strain, compared to when the reference length RL is elongated.

[0078] Although in the above embodiments, the thin region 5 is a region having a thickness T satisfying $T < T_0$, and the thin region 8 is a region having a thickness T satisfying $T < L$, in some embodiments, in addition to the above conditions of thickness T, the thickness T of the thin region 5 or the thin region 8 may be set to a minimum that can withstand the internal pressure applied to the precombustion-chamber forming portion 3. A thinner thickness T provides less strength than a thicker thickness T, but provides less heat capacity and stiffness around the nozzle holes 4, thus reducing thermal stress generated around the nozzle holes 4. When the thin region 5 or the thin region 8 is within the above range, it is possible to effectively suppress the occurrence of crack while maintaining strength necessary for the precombustion-chamber forming portion 3.

[0079] Further, in some embodiments described above, the thin region 5 or the thin region 8 does not include the peripheral edge of the precombustion-chamber-side opening 41 and the main-combustion-chamber-side opening 42 of the nozzle hole 4. In this case, since the nozzle hole diameter D and the nozzle hole length L of the nozzle hole 4 are maintained, it is possible to maintain the performance of the combustion flame injected from the nozzle hole 4.

[0080] According to the invention, the recess 35 is formed along the extension direction of the precombustion chamber central axis CS. However, according to other examples (not part of the invention), the recess may be formed along another direction. For instance, the recess may be formed along the circumferential direction of the tip portion 33 or the cylindrical portion 34.

Reference Signs List

[0081]

1	Precombustion chamber gas engine
11	Cylinder block
12	Cylinder head
13	Cylinder
14	Piston
15	Intake port
16	Exhaust port
17	Intake valve
18	Exhaust valve
19	Precombustion chamber cap
2	Main-chamber forming portion
20	Main combustion chamber
3, 3A to 3G	Precombustion-chamber forming portion

30	Precombustion chamber
31	Small-diameter-cylinder forming portion
310	Small-diameter cylinder chamber
311	Bottom surface
5 312	Wall surface
32	Large-diameter-cylinder forming portion
320	Large-diameter cylinder chamber
321	Wall surface
322	Stepped surface
10 33	Tip portion
331	Tip
332	Tip surface
333	Outer peripheral surface
34	Cylindrical portion
15 341	Small-diameter cylindrical portion
342	Large-diameter cylindrical portion
343	Stepped surface
344, 345	Outer peripheral surface
346	Position
20 35	Recess
36, 37	Outer recess
38	Inner recess
4	Nozzle hole
41	Precombustion-chamber-side opening
25 411	Upper edge
412	Lower edge
413	Intermediate edge
414	Chamfered portion
42	Main-combustion-chamber-side opening
30 421	Upper edge
422	Lower edge
5	Thin region
51	First thin region
52	Second thin region
35 53	Third thin region
6	Ignition device
61	Ignition portion
7	Precombustion-chamber-gas supply device
40 71	Precombustion-chamber-fuel-gas supply valve
8	Thin region
81	First thin region
82	Second thin region
45 83	Third thin region
84	Fourth thin region
CM	Main chamber central axis
CP	Central axis of nozzle hole
CS	Precombustion chamber central axis
50 D	Nozzle hole diameter
L, L1	Nozzle hole length
P1 to P3	Measurement point
RL	Reference length
RP	Reference plane
55 T, T0, T1	Thickness

Claims

1. A precombustion chamber gas engine comprising:

a main-chamber forming portion (2) forming a main combustion chamber (20); and
 a precombustion-chamber forming portion (3) forming a precombustion chamber (30) communicating with the main combustion chamber (20) via a plurality of nozzle holes (4),
 wherein the precombustion-chamber forming portion (3) includes a cylindrical portion (34) extending along an extension direction of a precombustion chamber central axis (CS) of the precombustion-chamber forming portion (3), and a tip portion (33) closing a main-combustion-chamber-side end of the cylindrical portion (34) and having the nozzle holes (4),
 wherein the tip portion (33) includes a thin region (52) having a thickness T of a wall surface (312) of the tip portion (33) satisfying $T < L$ where L is a length of each nozzle hole (4), and
characterized in that
 the thin region (52) includes a plurality of recesses (35) formed in a region including a portion of the tip portion (33) between each of a pair of nozzle holes (4) adjacent each other in a circumferential direction of the tip portion (33); wherein each recess (35) is shaped into a slit extending from an internal bottom surface (311) or from an external tip surface (332) of the tip portion (33) in the extension direction of the precombustion-chamber central axis (CS).

2. A precombustion chamber gas engine comprising:

a main-chamber forming portion (2) forming a main combustion chamber (20); and
 a precombustion-chamber forming portion (3, 3A-3G) forming a precombustion chamber (30) communicating with the main combustion chamber (20) via a plurality of nozzle holes (4),
 wherein the precombustion-chamber forming portion (3, 3A-3G) includes a cylindrical portion (34) extending along an extension direction of a precombustion chamber central axis of the precombustion-chamber forming portion (3, 3A-3G), and a tip portion (33) closing a main-combustion-chamber-side end of the cylindrical portion (34) and having the nozzle holes (4),
 wherein the tip portion (33) is located on a main combustion chamber side of a reference plane (RP) that extends in a direction perpendicular to the precombustion chamber central axis at a position away from an upper edge (411) of a precombustion-chamber-side opening (41) of each nozzle hole (4) by a length (RL), which is predetermined times a diameter (D) of each nozzle

hole (4) in a direction opposite to the main combustion chamber (2) along the extension direction of the precombustion chamber central axis, wherein the tip portion (33) includes a thin region (8) having a thickness T of a wall surface (312) of the tip portion (33) satisfying $T < T_0$ where T_0 is a thickness of the precombustion-chamber forming portion at the reference plane (RP), and
characterized in that
 the thin region (8) includes a plurality of recesses (35) formed in a region including a portion of the tip portion (33) between each of a pair of nozzle holes (4) adjacent each other in a circumferential direction of the tip portion (33); wherein each recess (35) is shaped into a slit extending from an internal bottom surface (311) or from an external tip surface (332) of the tip portion (33) in the extension direction of the precombustion-chamber central axis (CS).

3. The precombustion chamber gas engine according to claim 1,
 wherein the thin region (5) includes a tip (331) of the tip portion (33).

4. The precombustion chamber gas engine according to claim 2,
 wherein the thin region (5) includes a tip (331) of the tip portion (33).

5. The precombustion chamber gas engine according to claim 2 or 4,
 wherein the thin region (5) includes at least a part of a peripheral edge of a main-combustion-side opening of each nozzle hole (4) in the tip portion (33).

6. The precombustion chamber gas engine according to any one of claims 1 to 5,
 wherein the thin region (5) includes at least one outer recess formed in an outer peripheral surface of the tip portion (33) facing the main combustion chamber (20).

7. The precombustion chamber gas engine according to any one of claims 1 to 5,
 wherein the thin region (5) includes at least one inner recess formed in an inner peripheral surface of the tip portion (33) facing the precombustion chamber (30).

Patentansprüche

1. Gasmotor mit Vorverbrennungskammer, umfassend:

einen Hauptkammerbildungsabschnitt (2), der eine Hauptverbrennungskammer (20) bildet;

und
 einen Vorverbrennungskammerbildungsabschnitt (3), der eine Vorverbrennungskammer (30) bildet, die mit der Hauptverbrennungskammer (20) über eine Vielzahl von Düsenlöchern (4) kommuniziert, 5
 wobei der Vorverbrennungskammerbildungsabschnitt (3) einen zylindrischen Abschnitt (34), der sich entlang einer Ausdehnungsrichtung einer Vorverbrennungskammermittelachse (CS) des Vorverbrennungskammerbildungsabschnitts (3) erstreckt, und einen Spitzenabschnitt (33), der ein Hauptverbrennungskammerseitenende des zylindrischen Abschnitts (34) schließt und die Düsenlöcher (4) aufweist, beinhaltet, 10
 wobei der Spitzenabschnitt (33) eine dünne Region (52), aufweisend eine Dicke T einer Wandoberfläche (312) des Spitzenabschnitts (33), beinhaltet, die $T < L$ erfüllt, wo L eine Länge jedes Düsenlochs (4) ist, und 15

dadurch gekennzeichnet, dass

die dünne Region (52) eine Vielzahl von Vertiefungen (35) beinhaltet, die in einer Region gebildet sind, die einen Abschnitt des Spitzenabschnitts (33) zwischen jedem eines Paares von Düsenlöchern (4) nebeneinander in einer Umfangsrichtung des Spitzenabschnitts (33) beinhaltet; wobei jede Vertiefung (35) zu einem Schlitz geformt ist, der sich von einer internen Bodenfläche (311) oder von einer externen Spitzenfläche (332) des Spitzenabschnitts (33) in der Ausdehnungsrichtung der Vorverbrennungskammermittelachse (CS) erstreckt. 20
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2. Gasmotor mit Vorverbrennungskammer, umfassend

einen Hauptkammerbildungsabschnitt (2), der eine Hauptverbrennungskammer (20) bildet; und 40
 einen Vorverbrennungskammerbildungsabschnitt (3, 3A-3G), der eine Vorverbrennungskammer (30) bildet, die mit der Hauptverbrennungskammer (20) über eine Vielzahl von Düsenlöchern (4) kommuniziert, 45
 wobei der Vorverbrennungskammerbildungsabschnitt (3, 3A-3G) einen zylindrischen Abschnitt (34), der sich entlang einer Ausdehnungsrichtung einer Vorverbrennungskammermittelachse des Vorverbrennungskammerbildungsabschnitts (3, 3A-3G) erstreckt, und einen Spitzenabschnitt (33), der ein Hauptverbrennungskammerseitenende des zylindrischen Abschnitts (34) schließt und die Düsenlöcher (4) aufweist, beinhaltet, 50
 wobei der Spitzenabschnitt (33) an einer Hauptverbrennungskammerseite einer Referenzebe-

ne (RP), die sich in einer Richtung senkrecht zu der Vorverbrennungskammermittelachse erstreckt, an einer Position, die von einer oberen Kante (411) einer Vorverbrennungskammerseitenöffnung (41) jedes Düsenlochs (4) um eine Länge (RL), die ein vorgegebenes Vielfaches eines Durchmessers (D) jedes Düsenlochs (4) ist, in einer Richtung entgegengesetzt zu der Hauptverbrennungskammer (2) entlang der Ausdehnungsrichtung der Vorverbrennungskammermittelachse entfernt ist, liegt, wobei der Spitzenabschnitt (33) eine dünne Region (8) mit einer Dicke T einer Wandoberfläche (312) des Spitzenabschnitts (33) beinhaltet, die $T < T_0$ erfüllt, wo T_0 eine Dicke des Vorverbrennungskammerbildungsabschnitts an der Referenzebene (RP) ist, und

dadurch gekennzeichnet, dass

die dünne Region (8) eine Vielzahl von Vertiefungen (35) beinhaltet, die in einer Region gebildet sind, die einen Abschnitt des Spitzenabschnitts (33) zwischen jedem eines Paares von Düsenlöchern (4) nebeneinander in einer Umfangsrichtung des Spitzenabschnitts (33) beinhaltet; wobei jede Vertiefung (35) zu einem Schlitz geformt ist, der sich von einer internen Bodenfläche (311) oder von einer externen Spitzenfläche (332) des Spitzenabschnitts (33) in der Ausdehnungsrichtung der Vorverbrennungskammermittelachse (CS) erstreckt.

3. Gasmotor mit Vorverbrennungskammer nach Anspruch 1, wobei die dünne Region (5) eine Spitze (331) des Spitzenabschnitts (33) beinhaltet. 35
4. Gasmotor mit Vorverbrennungskammer nach Anspruch 2, wobei die dünne Region (5) eine Spitze (331) des Spitzenabschnitts (33) beinhaltet.
5. Gasmotor mit Vorverbrennungskammer nach Anspruch 2 oder 4, wobei die dünne Region (5) zumindest einen Teil einer Umfangskante einer Hauptverbrennungsseitenöffnung jedes Düsenlochs (4) in dem Spitzenabschnitt (33) beinhaltet. 45
6. Gasmotor mit Vorverbrennungskammer nach einem der Ansprüche 1 bis 5, wobei die dünne Region (5) zumindest eine äußere Vertiefung beinhaltet, die in einer äußeren Umfangsfläche des Spitzenabschnitts (33) gebildet ist, die der Hauptverbrennungskammer (20) zugewandt ist. 50
7. Gasmotor mit Vorverbrennungskammer nach einem der Ansprüche 1 bis 5, wobei die dünne Region (5) zumindest eine innere

Vertiefung beinhaltet, die in einer inneren Umfangsfläche des Spitzenabschnitts (33) gebildet ist, die der Vorverbrennungskammer (30) zugewandt ist.

Revendications

1. Moteur à gaz à chambre de précombustion comprenant :

une portion de formation de chambre principale (2) formant une chambre de combustion principale (20) ; et

une portion de formation de chambre de précombustion (3) formant une chambre de précombustion (30) communiquant avec la chambre de combustion principale (20) via une pluralité de trous de buse (4),

dans lequel la portion de formation de chambre de précombustion (3) inclut une portion cylindrique (34) s'étendant le long d'une direction d'extension d'un axe central de chambre de précombustion (CS) de la portion de formation de chambre de précombustion (3), et une portion de bout (33) fermant une extrémité côté chambre de combustion principale de la portion cylindrique (34) et présentant les trous de buse (4),

dans lequel la portion de bout (33) inclut une région mince (52) présentant une épaisseur T d'une surface de paroi (312) de la portion de bout (33) satisfaisant à $T < L$ où L est une longueur de chaque trou de buse (4), et

caractérisé en ce que

la région mince (52) inclut une pluralité d'évidements (35) formés dans une région comportant une portion de la portion de bout (33) entre chacun d'une paire de trous de buse (4) adjacents les uns aux autres dans une direction circonférentielle de la portion de bout (33) ; dans lequel chaque évidement (35) est formé dans une fente s'étendant depuis une surface inférieure interne (311) ou depuis une surface de bout externe (332) de la portion de bout (33) dans la direction d'extension de l'axe central de chambre de précombustion (CS).

2. Moteur à gaz à chambre de précombustion comprenant :

une portion de formation de chambre principale (2) formant une chambre de combustion principale (20) ; et

une portion de formation de chambre de précombustion (3, 3A-3G) formant une chambre de précombustion (30) communiquant avec la chambre de combustion principale (20) via une pluralité de trous de buse (4), dans lequel la portion de formation de chambre

de précombustion (3, 3A-3G) inclut une portion cylindrique (34) s'étendant le long d'une direction d'extension d'un axe central de chambre de précombustion de la portion de formation de chambre de précombustion (3, 3A-3G), et une portion de bout (33) fermant une extrémité côté chambre de combustion principale de la portion cylindrique (34) et présentant les trous de buse (4),

dans lequel la portion de bout (33) est située sur un côté chambre de combustion principale d'un plan de référence (RP) qui s'étend dans une direction perpendiculaire à l'axe central de chambre de précombustion dans une position loin d'une arête supérieure (411) d'une ouverture côté chambre de précombustion (41) de chaque trou de buse (4) d'une longueur (RL) qui est à des moments prédéterminés un diamètre (D) de chaque trou de buse (4) dans une direction opposée à la chambre de combustion principale (2) le long de la direction d'extension de l'axe central de chambre de précombustion,

dans lequel la portion de bout (33) inclut une région mince (8) présentant une épaisseur T d'une surface de paroi (312) de la portion de bout (33) satisfaisant à $T < T_0$ où T_0 est une épaisseur de la portion de formation de chambre de précombustion au niveau du plan de référence (RP), et

caractérisé en ce que

la région mince (8) inclut une pluralité d'évidements (35) formés dans une région comportant une portion de la portion de bout (33) entre chacun d'une paire de trous de buse (4) adjacents les uns aux autres dans une direction circonférentielle de la portion de bout (33) ; dans lequel chaque évidement (35) est formé dans une fente s'étendant depuis une surface inférieure interne (311) ou depuis une surface de bout externe (332) de la portion de bout (33) dans la direction d'extension de l'axe central de chambre de précombustion (CS).

3. Moteur à gaz à chambre de précombustion selon la revendication 1, dans lequel la région mince (5) inclut un bout (331) de la portion de bout (33).

4. Moteur à gaz à chambre de précombustion selon la revendication 2, dans lequel la région mince (5) inclut un bout (331) de la portion de bout (33).

5. Moteur à gaz à chambre de précombustion selon la revendication 2 ou 4, dans lequel la région mince (5) inclut au moins une partie d'une arête périphérique d'une ouverture côté combustion principale de chaque trou de buse (4)

dans la portion de bout (33).

6. Moteur à gaz à chambre de précombustion selon l'une quelconque des revendications 1 à 5, dans lequel la région mince (5) inclut au moins un évidement extérieur formé dans une surface périphérique extérieure de la portion de bout (33) tournée vers la chambre de combustion principale (20). 5
7. Moteur à gaz à chambre de précombustion selon l'une quelconque des revendications 1 à 5, dans lequel la région mince (5) inclut au moins un évidement intérieur formé dans une surface périphérique intérieure de la portion de bout (33) tournée vers la chambre de précombustion (30). 10 15

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FIG. 1

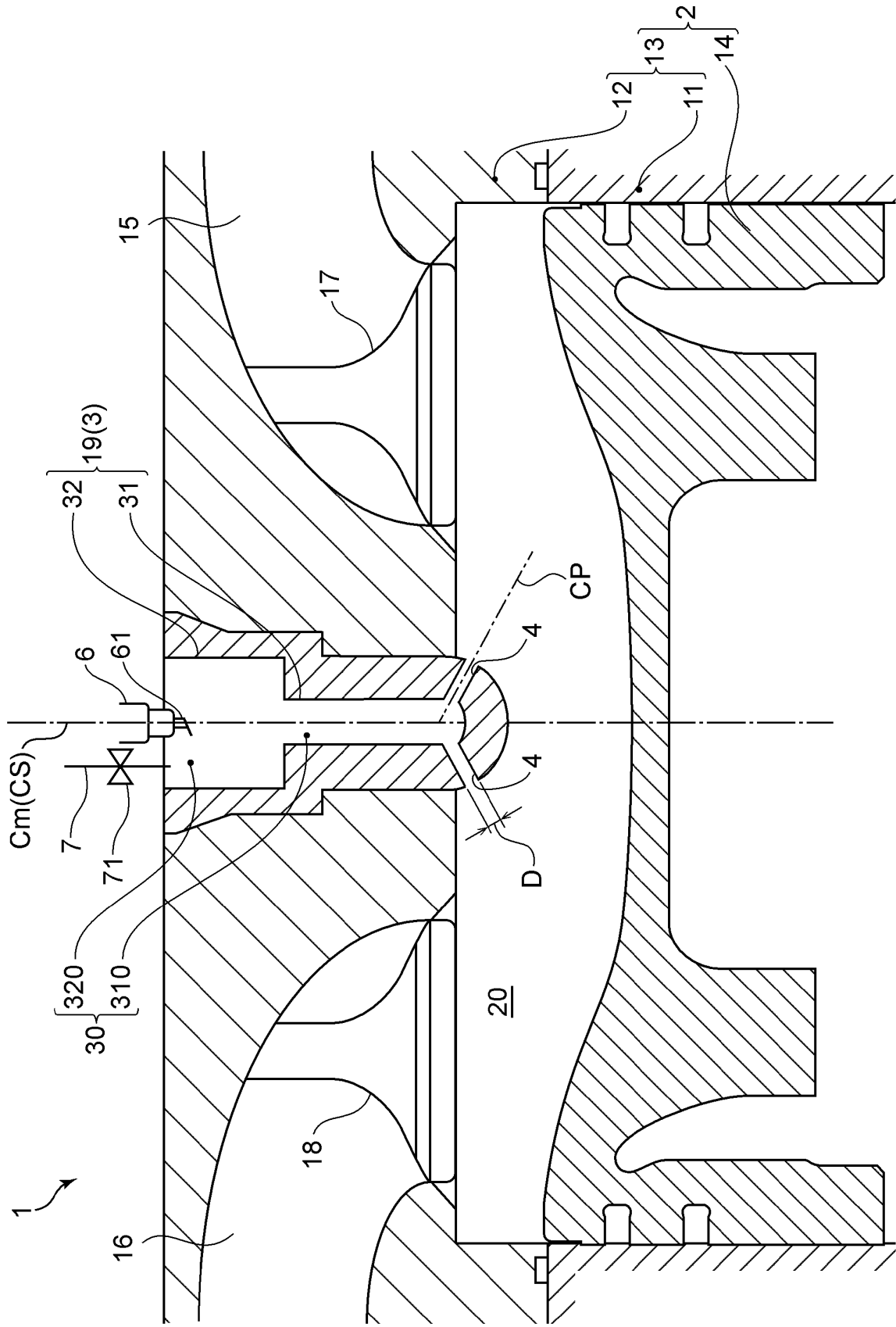


FIG. 2

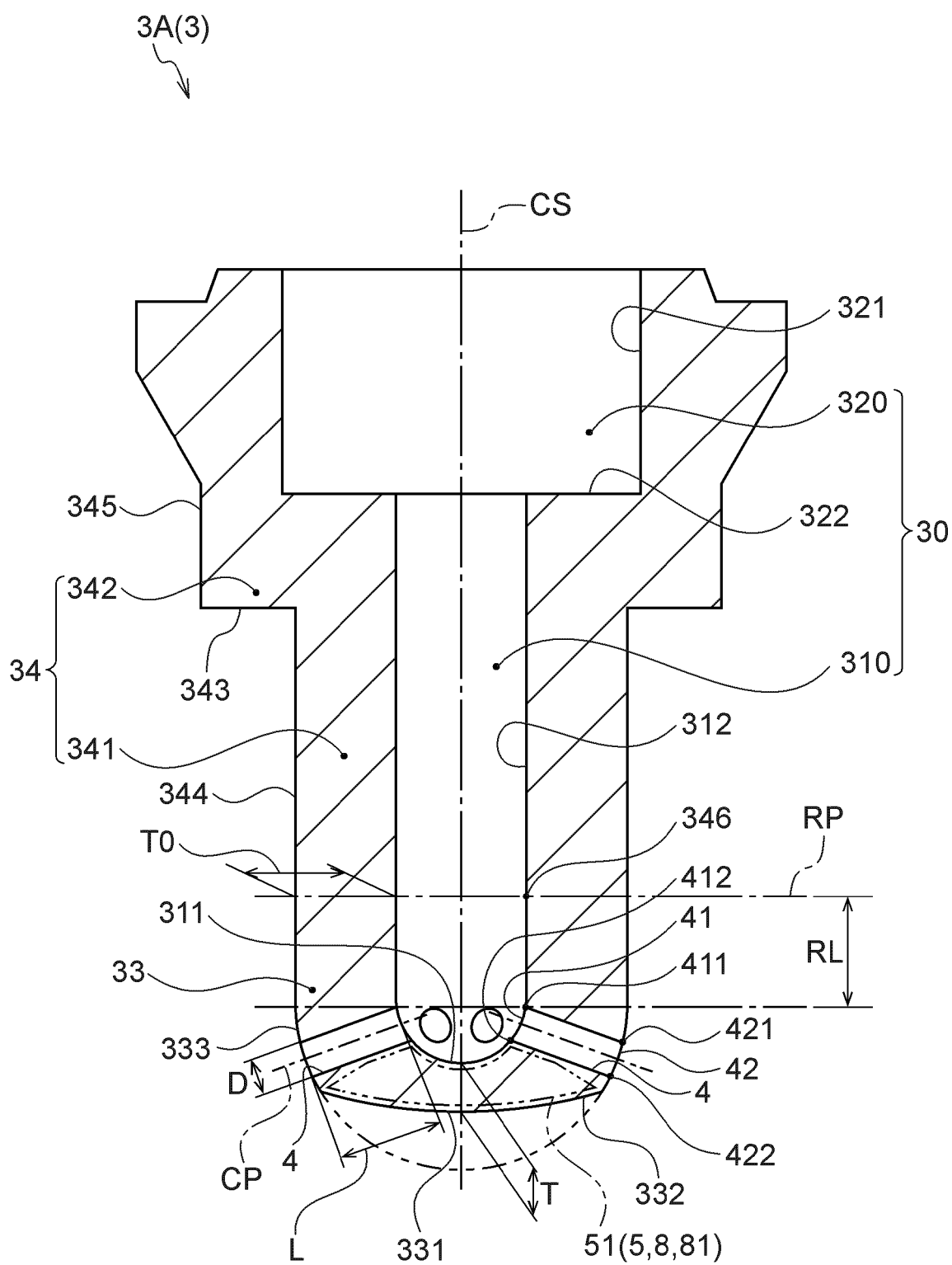


FIG. 3

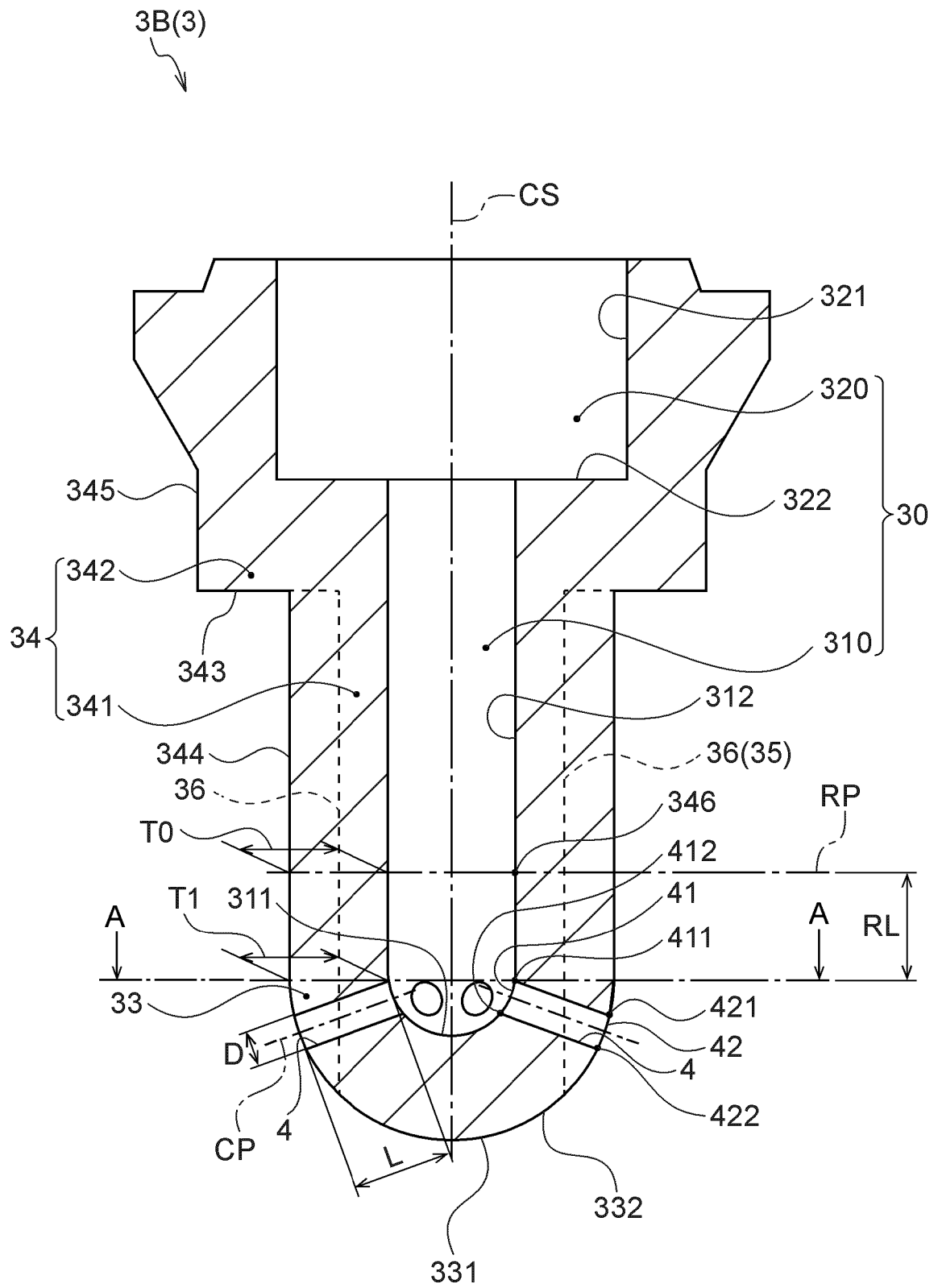


FIG. 4

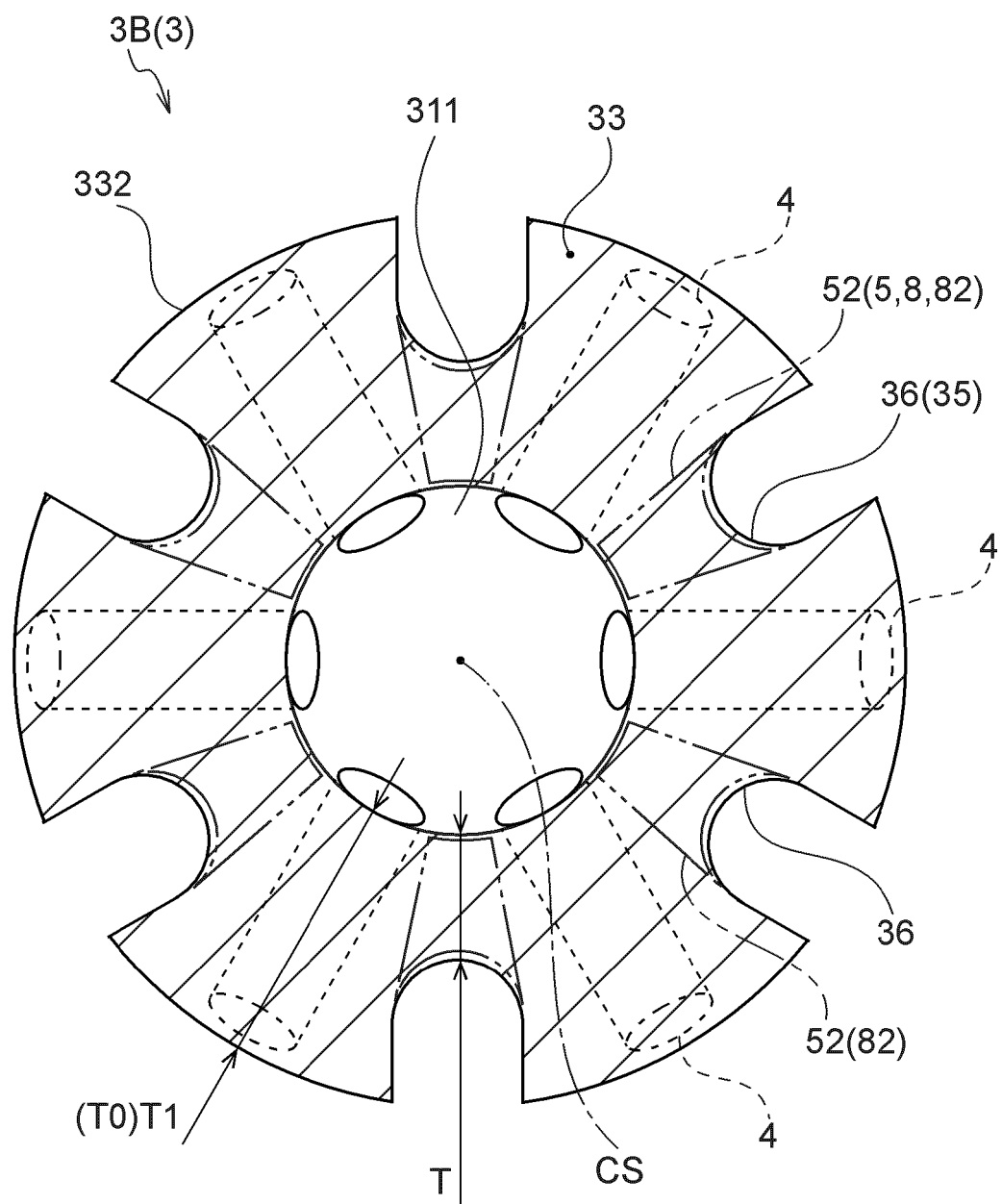


FIG. 5

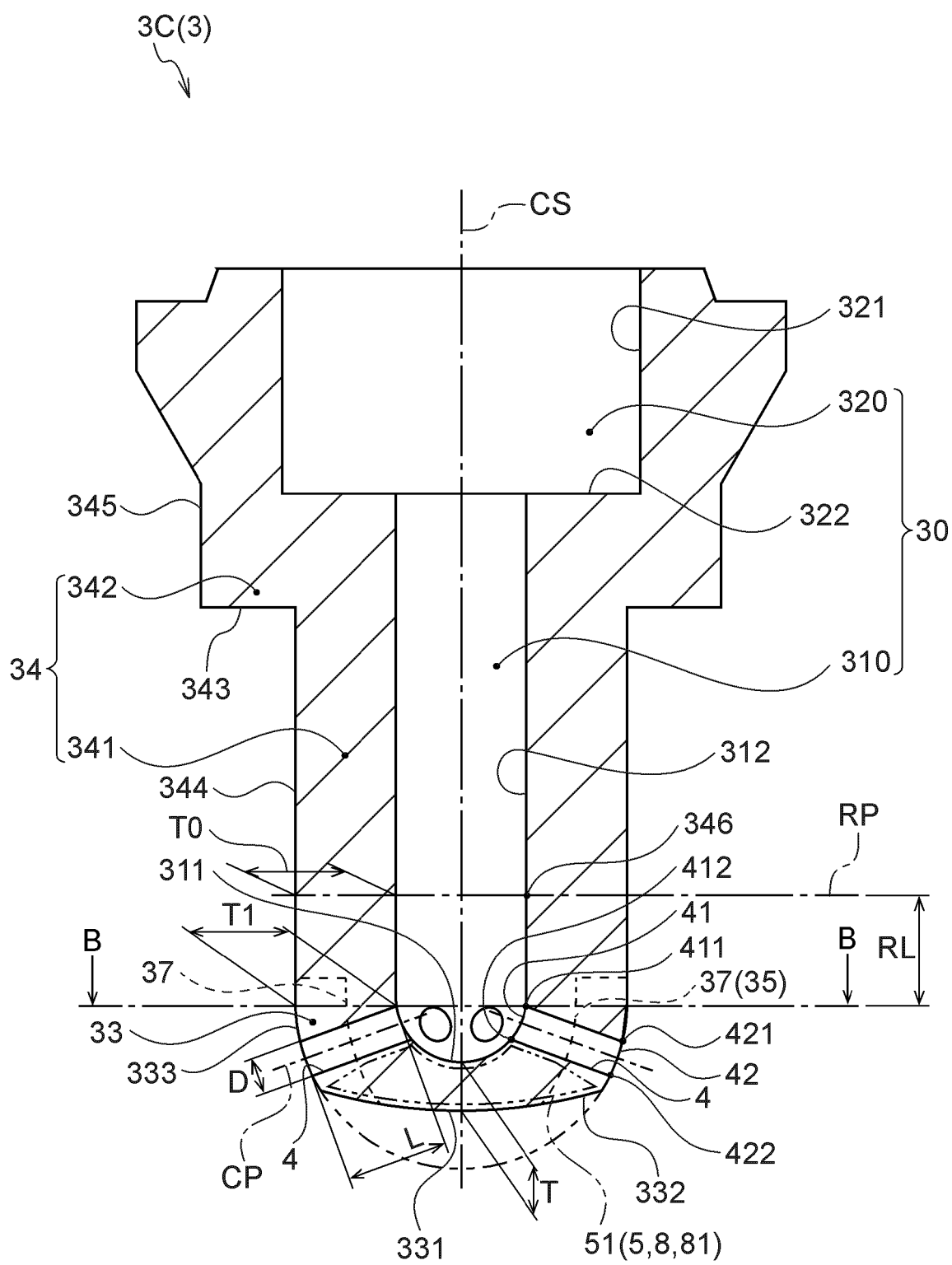


FIG. 6

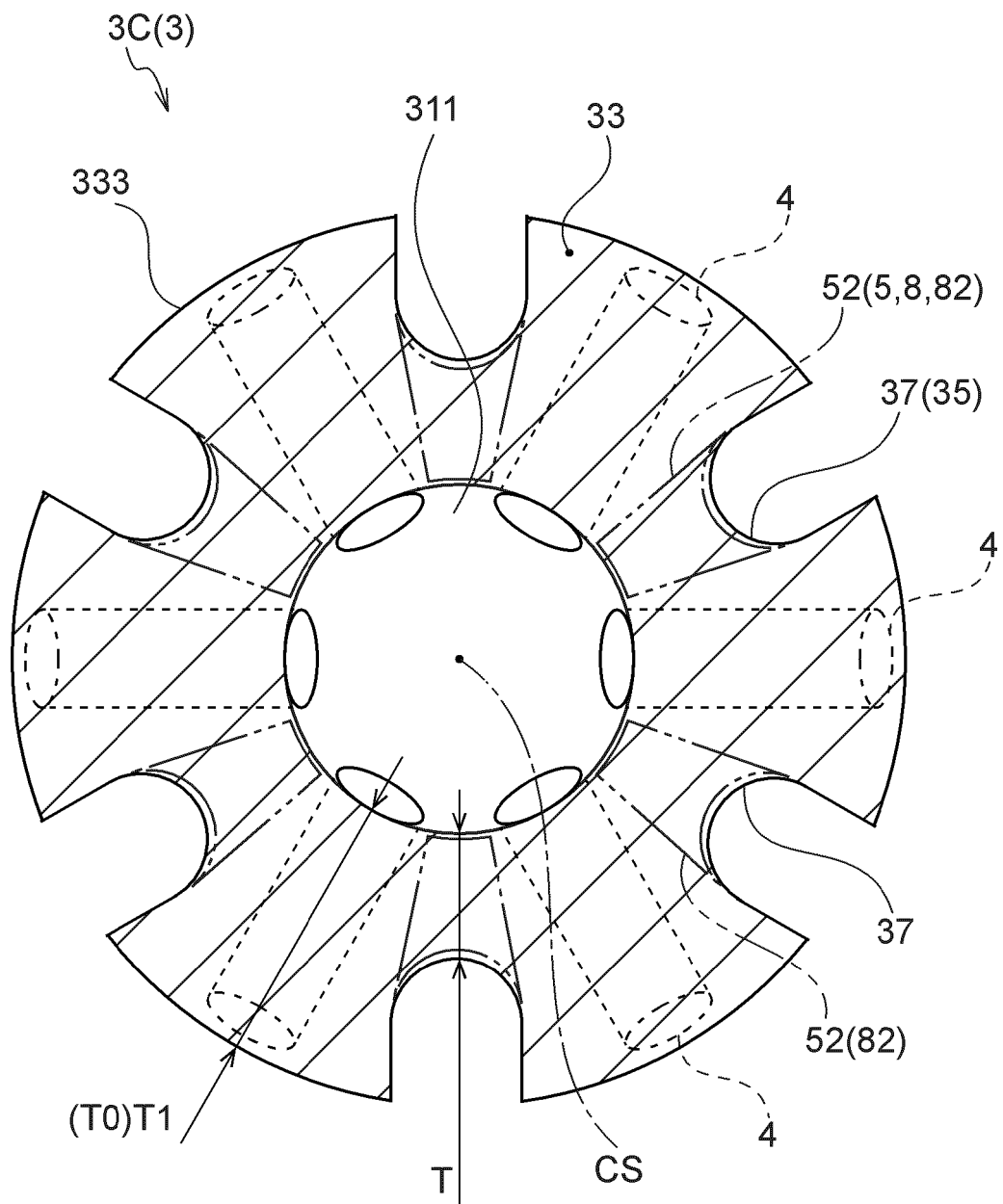


FIG. 7

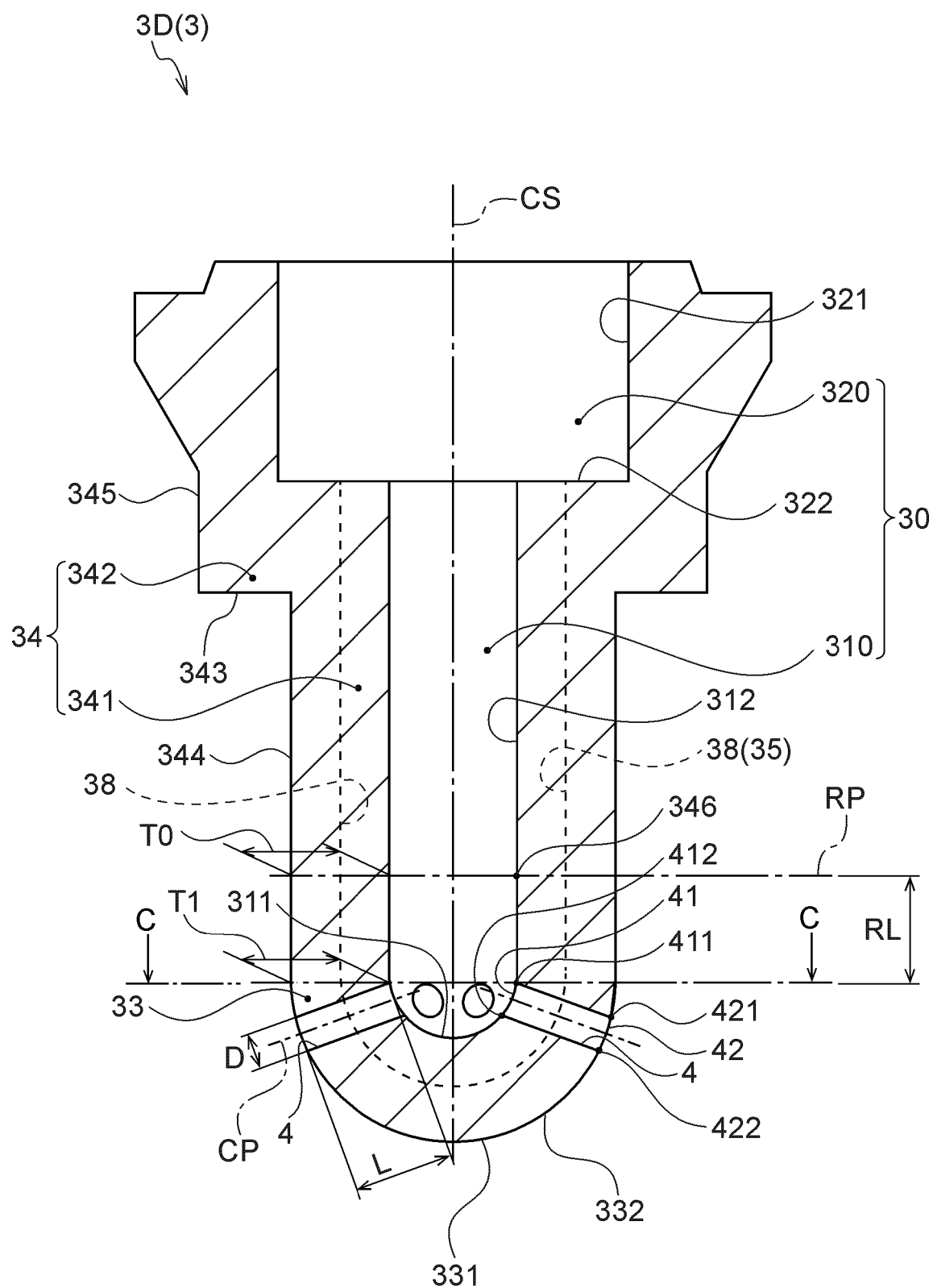


FIG. 8

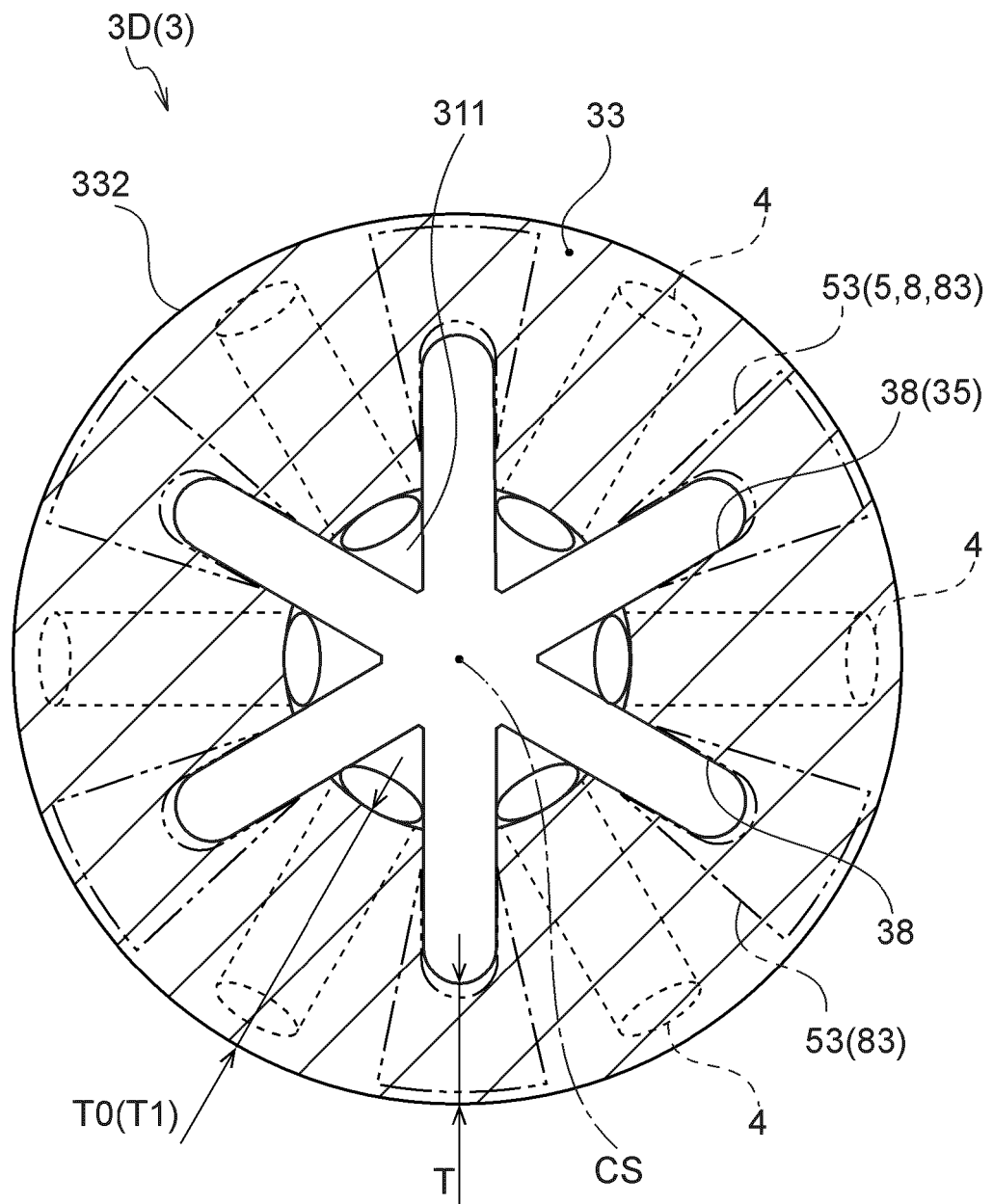


FIG. 9

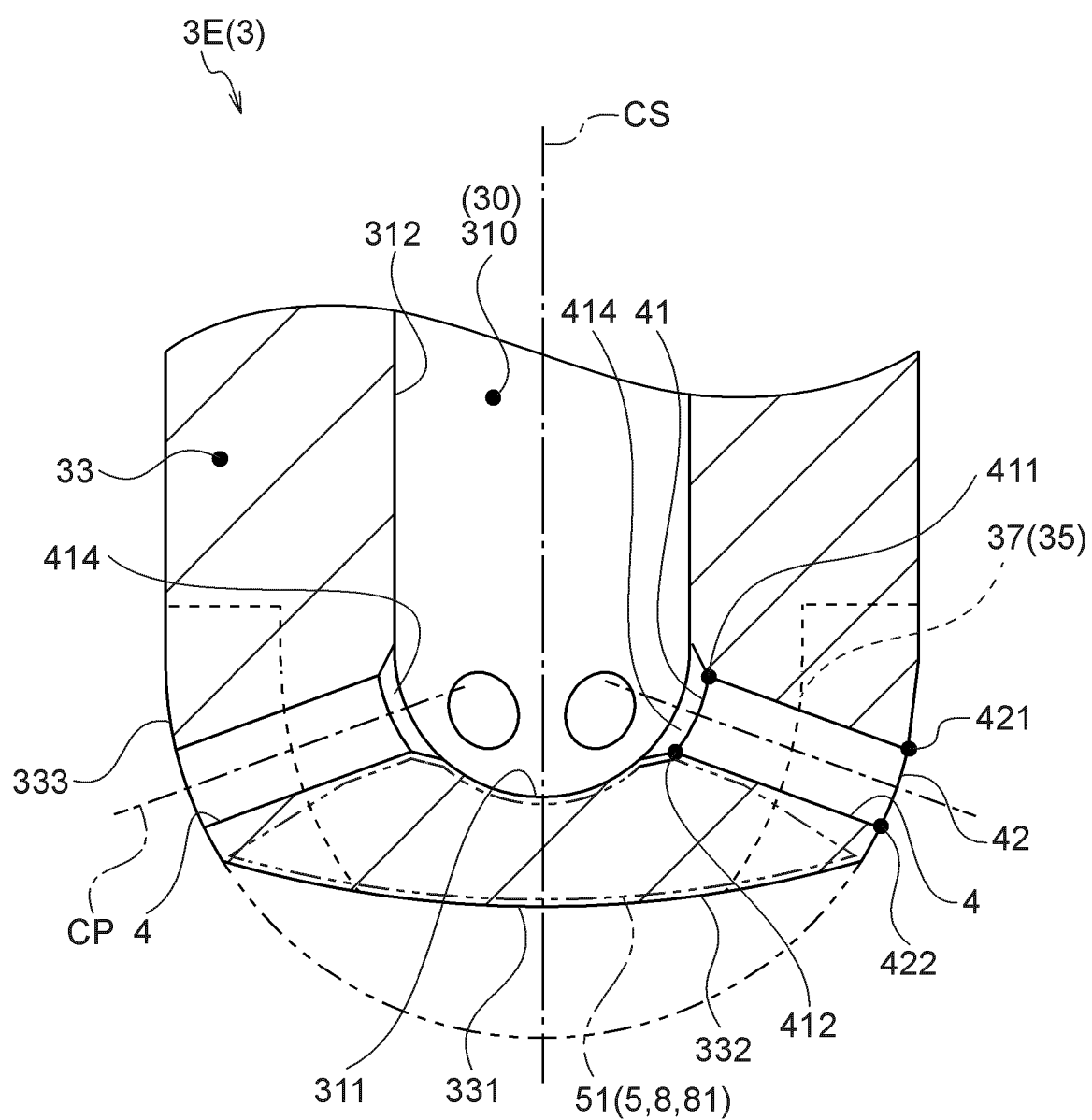


FIG. 10

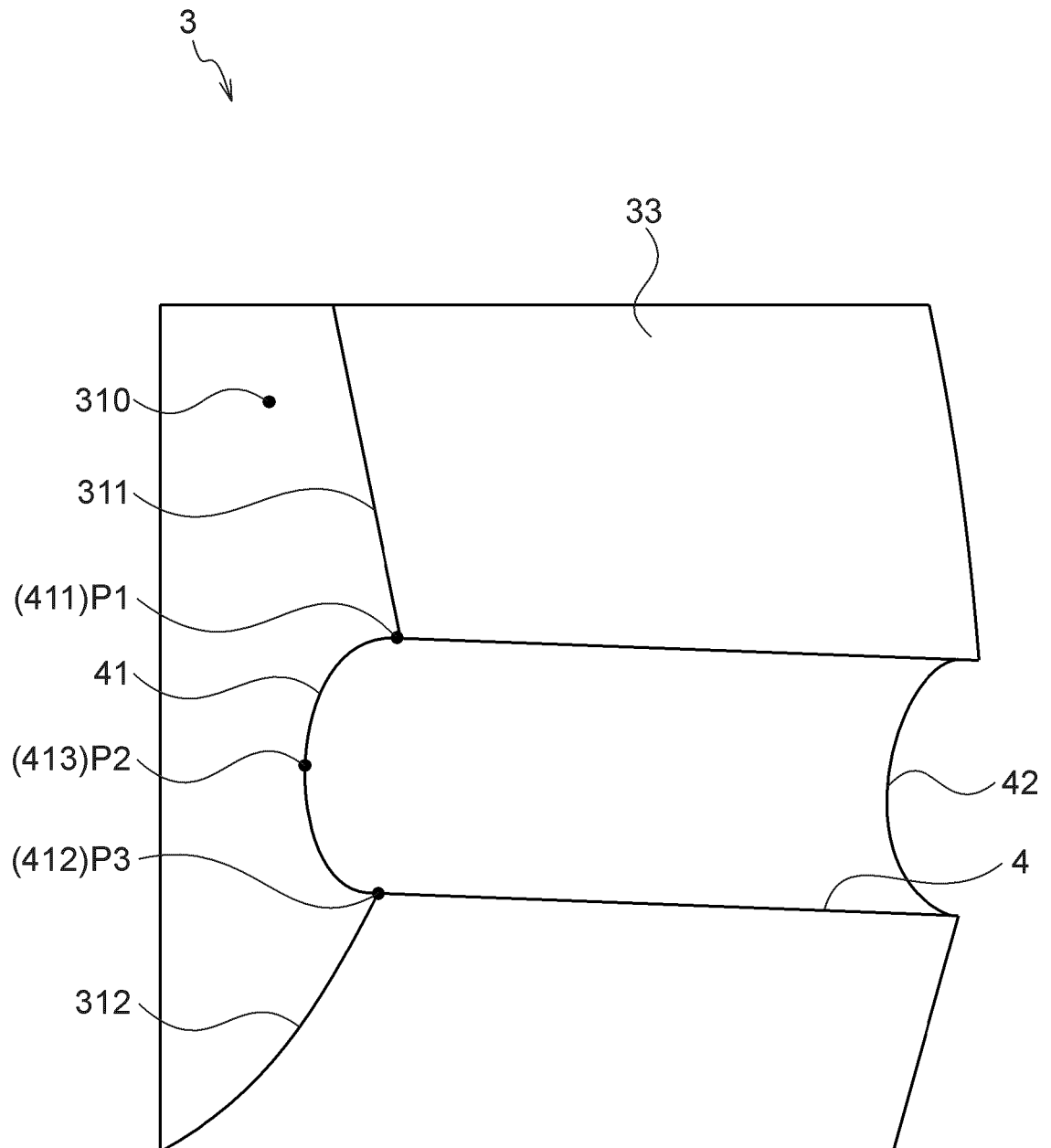


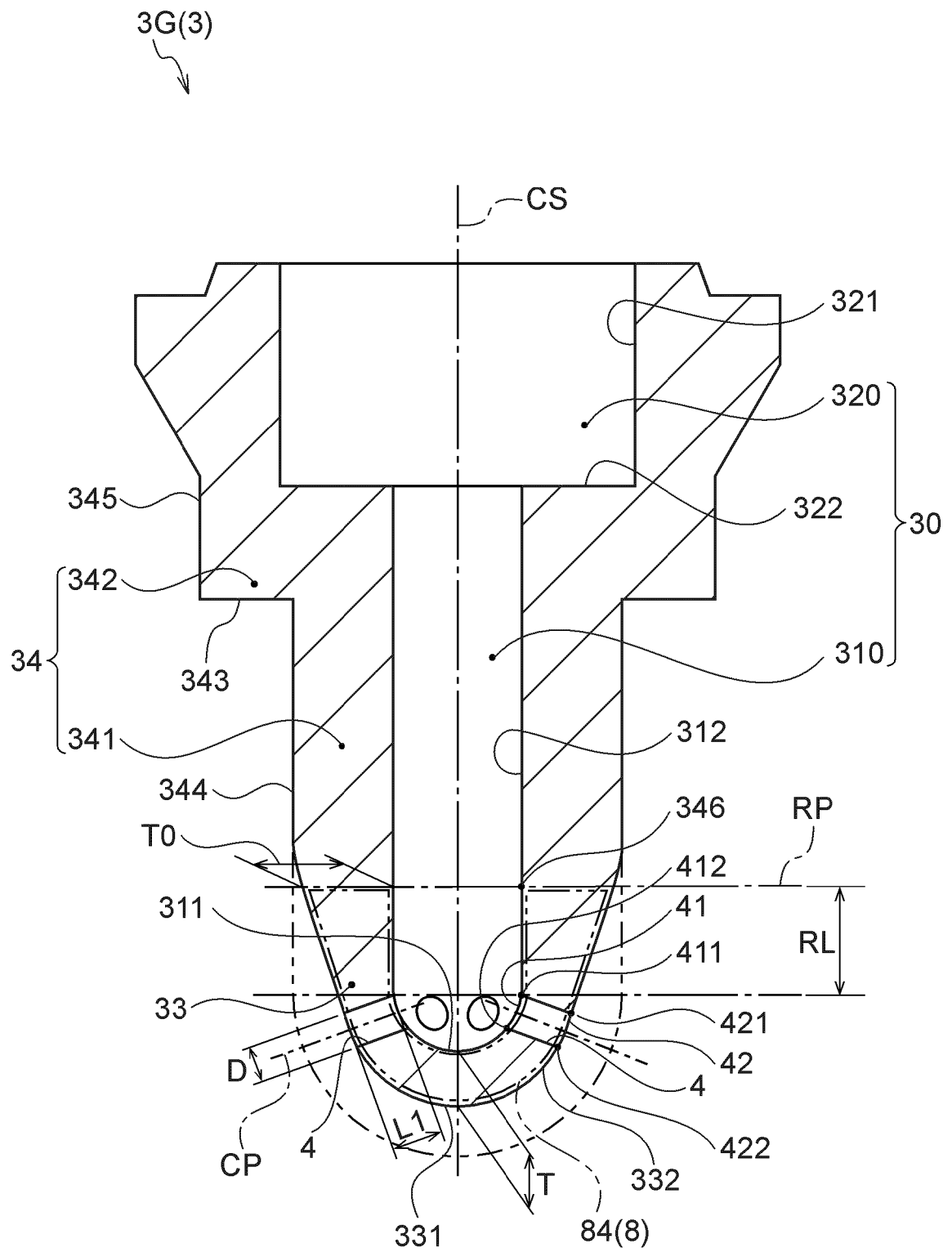
FIG. 11

	Dimensionless strain range (-)		
	P1	P2	P3
3F	1	1	1
3A	1	0.875	1
Reduction rate (%)		$\Delta 12.5$	

FIG. 12

	Dimensionless strain range (-)		
	P1	P2	P3
3F	1	1	1
3E	0.690	0.795	0.718
Reduction rate (%)	$\Delta 31.0$	$\Delta 20.5$	$\Delta 28.2$

FIG. 13



REFERENCES CITED IN THE DESCRIPTION

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